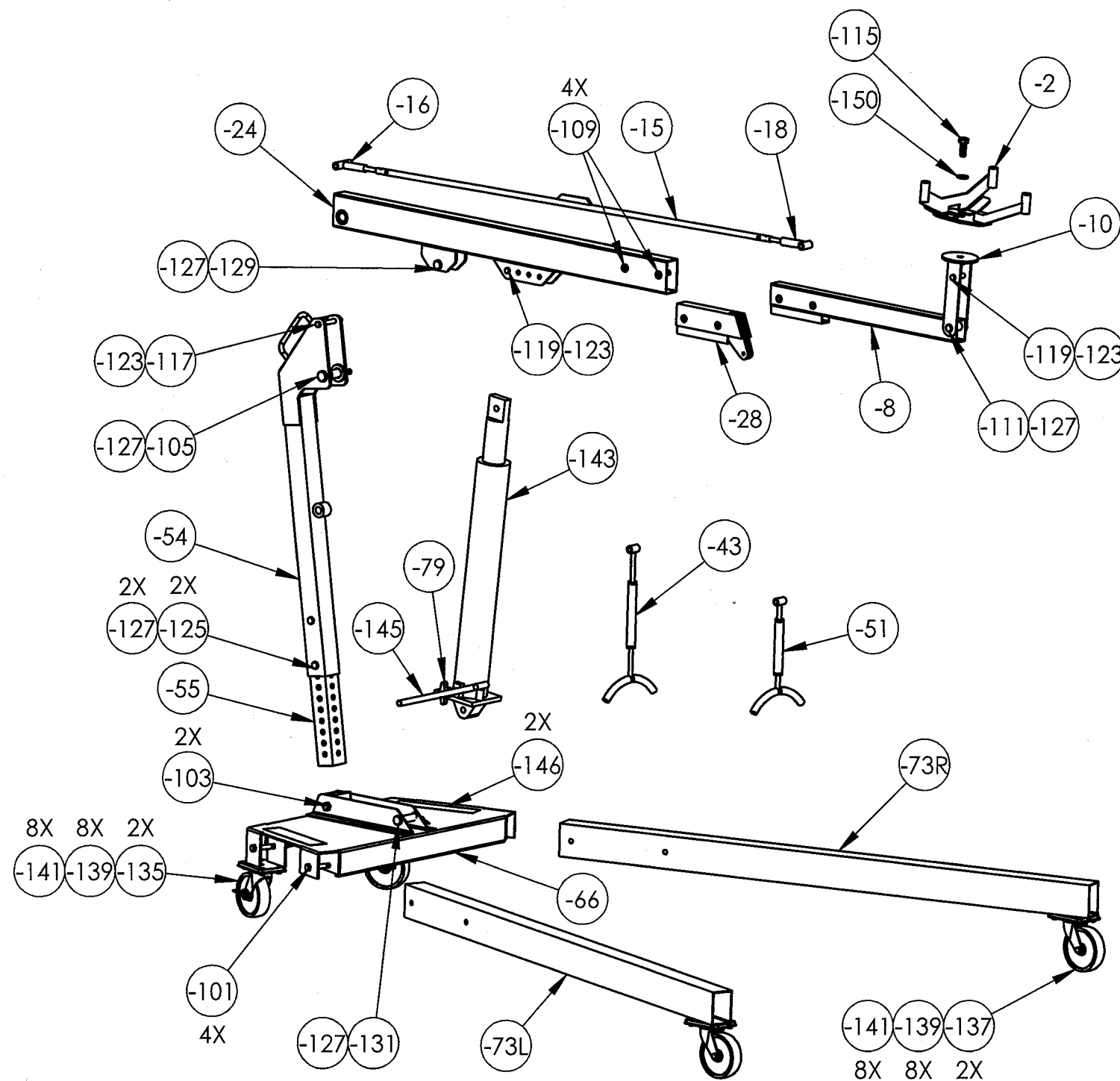


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SEE ATTACHED DEVIATION

DART
AEROSPACE

1270 Aberdeen St., Hawkesbury, ON. K6A1K7
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE			MD-500 ENGINE LIFT	
DWG NO.	RBT18625	REV	L	CUSTOMER 1 OF 3
SCALE	1:16	DATE	11/07/2019	SHEET 1 OF 76

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CUSTOMER PARTS LIST

ITEM #	Description	QTY.	Part #
-2	TRANSMISSION ADAPTER	1	RBT18625-002
-8	TRANSMISSION ADAPTER TUBE	1	RBT18625-008
-10	TRANSMISSION ADAPTER PIVOT	1	RBT18625-010
-15	TIE-ROD ASSEMBLY	1	RBT18625-015
-16	LH BUSHING ASSEMBLY	1	RBT18625-016
-18	RH BUSHING ASSEMBLY	1	RBT18625-018
-24	BOOM ASSEMBLY	1	RBT18625-024
-28	ENGINE ADAPTER ASSEMBLY	1	RBT18625-028
-43	LARGE TURNBUCKLE ASSEMBLY	1	RBT18625-043
-51	SMALL TURNBUCKLE ASSEMBLY	1	RBT18625-051
-54	UPRIGHT ASSEMBLY	1	RBT18625-054
-55	MAST	1	RBT18625-055
-66	BASE PLATE ASSEMBLY	1	RBT18625-066
-73R	RIGHT LEG WELDMENT	1	RBT18625-073R
-73L	LEFT LEG WELDMENT	1	RBT18625-073L
-79	KNOB ASSEMBLY	1	RBT18625-079
-101	HEX BOLT 3/8-16 X 2-3/4	4	RBT18625-101
-103	HEX BOLT 7/16-14 X 2-3/4	2	RBT18625103
-105	CLEVIS PIN Ø3/4 X 2-1/2	1	RBT18625-105
-109	B.H. SOCKET HEAD CAP SCREW 3/8-16 X 5/8	4	RBT18625-109
-111	CLEVIS PIN	1	RBT18625-111
-115	HEX BOLT 1/2-13 X 1-1/4	1	RBT18625-115
-117	CLEVIS PIN	1	RBT18625-117
-119	CLEVIS PIN	2	RBT18625-119
-123	HAIRPIN FOR Ø3/8 CLEVIS PIN	3	RBT18625-123
-125	CLEVIS PIN	2	RBT18625-125
-127	HAIRPIN FOR Ø7/16 CLEVIS PIN	6	RBT18625-127
-129	CLEVIS PIN	1	RBT18625-129
-131	CLEVIS PIN	1	RBT18625-131
-135	SWIVEL CASTER W/BRAKE	2	RBT18625-135
-137	RIGID CASTER	2	RBT18625-137
-139	B.H. SOCKET HEAD CAP SCREW 5/16-18 X 3/8	16	RBT18625-139
-141	LOCK WASHER Ø5/16	16	RBT18625-141
-143	HYDRAULIC JACK	1	RBT18625-143
-145	HANDLE HYD. JACK	1	RBT18625-145
-146	NO-SKID	2	RBT18625-146
-150	FLAT WASHER Ø1/2	1	RBT18625-150

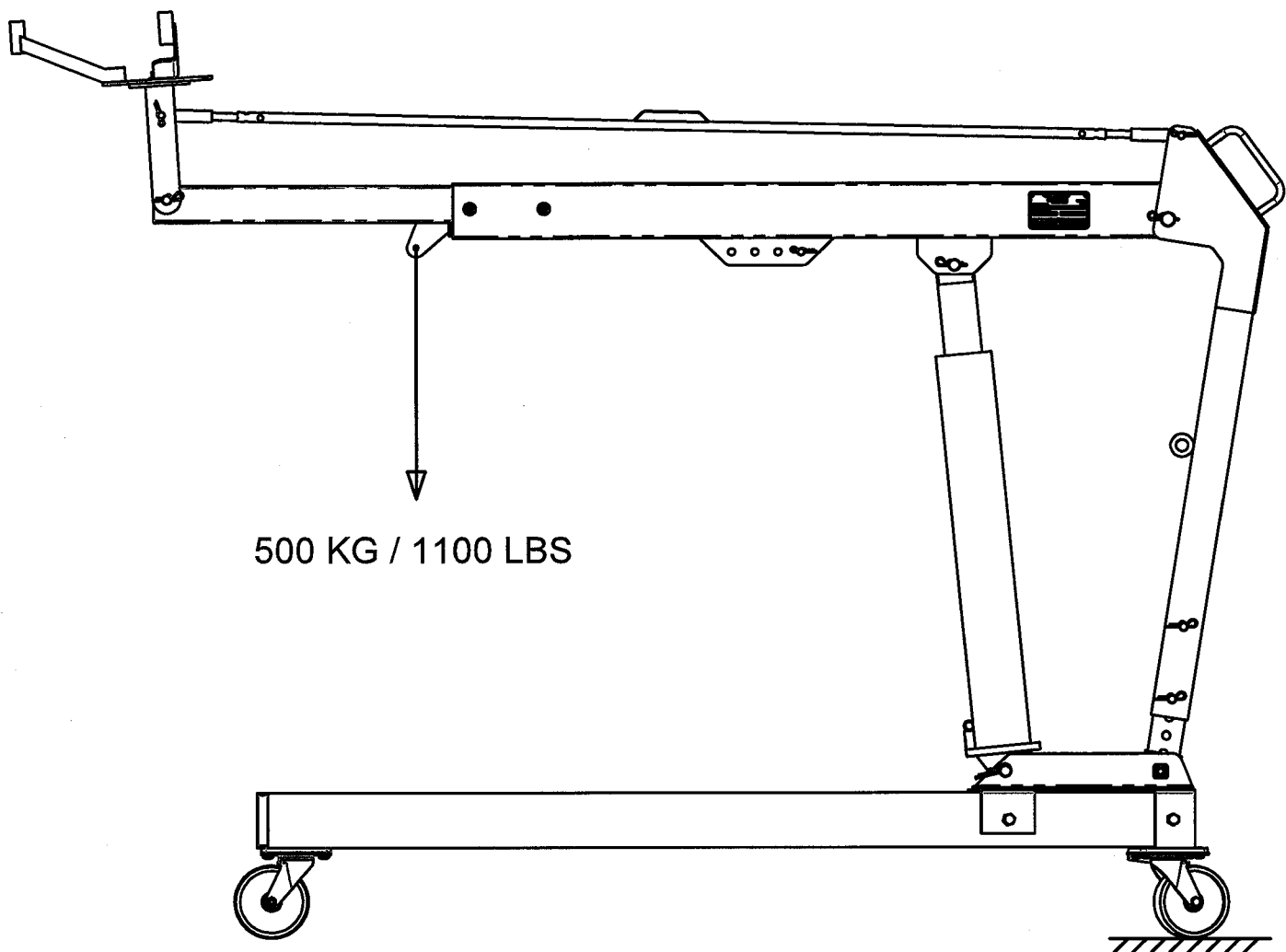
SEE ATTACHED DEVIATION



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1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE			
MD-500 ENGINE LIFT			
DWG NO.	RBT18625	REV	L
SCALE	1:1	DATE	11/07/2019
		CUSTOMER 2 OF 3	
		SHEET 2 OF 76	

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LOAD TEST PROCEDURE


1. AFTER INSPECTION, FIX ENGINE LIFT INTO PLACE BY LOCKING THE REAR CASTER WHEELS. ATTACH AN APPROPRIATE TEST WEIGHT OF 500 KG / 1100 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTIONS, OR DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT ENGINE LIFT, CHECKING FOR CRACKS, DEFLECTIONS, OR DISTORTIONS

INSPECTOR: _____ **SEE ATTACHED DEVIATION**

TESTER: _____

S/N: _____



DATE: _____

 1270 Aberdeen St., Hawkesbury, ON. K6A1K7 1-800-556-4166 e-mail: sales@dartaero.com dartaerospace.com		
TITLE MD-500 ENGINE LIFT		
DWG NO. RBT18625	REV L	CUSTOMER 3 OF 3
SCALE 1:1	DATE 11/07/2019	SHEET 3 OF 76

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
L		ADDED CUSTOMER LOAD TEST SHEET AND FIRST ARTICLE LOAD TEST SHEET. ADDED ENGRAVING NOTE FOR DART PLACARD ON SHEET 6	11/07/2019	KPT	19-1250

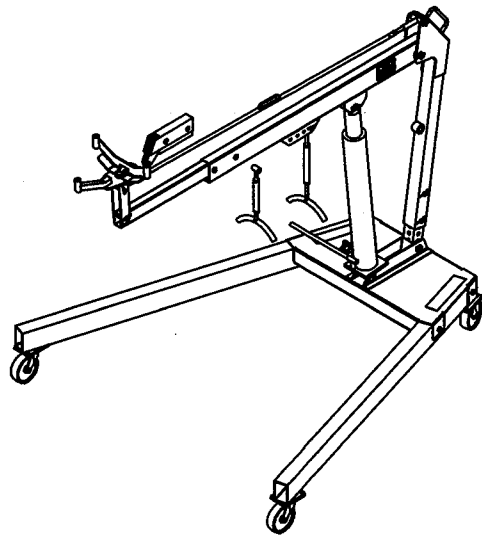
SEE ATTACHED DEVIATION

	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625	REV L
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ±.5° .X ± .1 SURFACES = 125/✓
HEAT TREAT	
FINISH	
SPEC	
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: 	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 4 OF 76

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ASSY QTY -79	ASSY QTY -73L	ASSY QTY -73R	ASSY QTY -66	ASSY QTY -54	ASSY QTY -51	ASSY QTY -43	ASSY QTY -28	ASSY QTY -24	ASSY QTY -18	ASSY QTY -16	ASSY QTY -15	ASSY QTY -10	ASSY QTY -8	ASSY QTY -2	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
														X		-2	1	TRANSMISSION ADAPTER			6
																-2A	2	ATTACH TUBE	CDS		7
																1	-2B	1	ATTACH TUBE	CDS	8
																1	-3	1	ATTACH PLATE	1018/1020 CR	9
																1	-5	1	BRACKET	STEEL TUBE	10
																1	-7	1	WING BRACKET	A36/1018/1020 HR	11
													X			-8	1	TRANSMISSION ADAPTER TUBE			12
												1				-9		1	DISK	1018/1020 CR	13
												X				-10	1	TRANSMISSION ADAPTER PIVOT			14
												2				-11		1	STRAP	A36/1018/1020 HR	15
												1				-12		1	BUSHING	1018/1020 CR	16
												1				-13		1	ADAPTER TUBE	STEEL TUBE	17
							2									-14		2	THREADED BUSHING	1018/1020 CR	18
												X				-15	1	1	TIE-ROD ASSEMBLY		19
												1				-15A		1	LH THREAD	STEEL	20
												1				-15B		1	RH THREAD	STEEL	21
												1				-15C		1	TIE-ROD TUBE	CDS	22
												1				-15D		1	TAB	1018/1020 CR	23
										X						-16	1	1	LH BUSHING ASSEMBLY		24
										1						-16A		1	EYE	CDS	25
										1						-16B		1	LH THREAD BUSHING	1018/1020 CR	26
								2								-17		1	RAM ATTACH	A36/1018/1020 HR	27
									X							-18	1	1	RH BUSHING ASSEMBLY		28
									1							-18A		1	EYE	CDS	29
									1							-18B		1	RH THREAD BUSHING	1018/1020 CR	30
								2								-19		1	TURNBUCKLE ATTACH	A36/1018/1020 HR	31
								1								-21		1	BUSHING	DOM	32
								1								-23		1	BOOM	STEEL TUBE	33
								X								-24	1	1	BOOM ASSEMBLY		34
							1									-25		1	ENGINE ADAPTER TUBE	STEEL TUBE	35
							1								1	-26		1	TUBE	STEEL TUBE	36
								2								-27		1	ENGINE ATTACH	1018/1020 CR	37
								1								-27A		1	SPACER	1018/1020 CR	38
								X								-28	1	1	ENGINE ADAPTER ASSEMBLY		39
																-29		1	TUBE	CDS	40
							1	1								-31		1	LH THREADED BUSHING	1018/1020 CR	41
							1	1								-33		1	THREADED BUSHING	1018/1020 CR	42
							1	1								-35		1	EYE	CDS	43
								1								-37		1	LH THREADED STUD	STEEL	44
								1								-39		1	THREADED STUD	STEEL	45
							1	1								-41		1	ARCH	1018/1020 CR	46
							2	2								-41A		1	HOSE	RUBBER	47, 51
								X								-43	1	1	LARGE TURNBUCKLE ASSEMBLY		47
								1								-45		1	TUBE	CDS	48
								1								-47		1	LH THREADED STUD	STEEL	49
								1								-49		1	THREADED STUD	STEEL	50
								X								-51	1	1	SMALL TURNBUCKLE ASSEMBLY		51
								1								-53		1	UPRIGHT	STEEL TUBE	52
								1								-53A		1	STORAGE RING	1018/1020 CR	53
								X								-54	1	1	UPRIGHT ASSEMBLY		54
																-55	1	1	MAST	STEEL TUBE	55
																-57		1	SOCKET	STEEL TUBE	56
								2								-59		1	PIVOT BRACKET	A36/1018/1020 CR	57
								1								-60		1	HANDLE PLATE	1018/1020 CR	58
								2								-61		1	BUSHING	DOM	59
								1								-62		1	HANDLE	1018/1020 CR	60

SEE ATTACHED DEVIATION

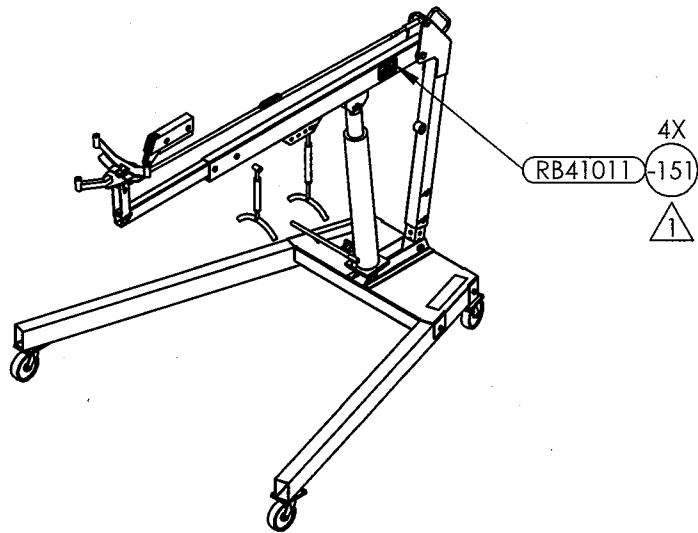


DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625	REV L
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSEY	MD-500
APPROVED: [Signature]	
SCALE 1:16	DATE 11/07/2019 SHEET 5 OF 76

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ASSY QTY -79	ASSY QTY -73L	ASSY QTY -73R	ASSY QTY -66	ASSY QTY -54	ASSY QTY -51	ASSY QTY -43	ASSY QTY -28	ASSY QTY -24	ASSY QTY -18	ASSY QTY -16	ASSY QTY -15	ASSY QTY -10	ASSY QTY -8	ASSY QTY -2	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1													-63		BASE	A36/1018/1020 HR		61
			1													-65L		ANGLE BRACKET	A36/1018/1020 HR		62
			1													-65R		ANGLE BRACKET	A36/1018/1020 HR		63
			X													-66	1	BASE PLATE ASSEMBLY			64
			2													-67		FORWARD TAB	A36/1018/1020 HR		65
			2													-69		FORWARD TAB	A36/1018/1020 HR		66
			2													-71		STIFFENER	A36/1018/1020 HR		67
		X														-73R	1	RIGHT LEG WELDMENT			69
	X															-73L	1	LEFT LEG WELDMENT			68
	1	1														-73		LEG	STEEL TUBE		70
	1	1	2													-75		WHEEL PLATE	1018/1020 CR		72
				1												-76		BACK PLATE	A36/1018/1020 HR		73
X																-79	1	KNOB ASSEMBLY			74
1																-81		HAND KNOB	IRON	MSC #82397241 (MODIFIED)	75
1																B/O -99		ROLL PIN	STEEL	Ø5/32 X 3/4 (MCMaster-CARR #90692A711)	74
																B/O -101	4	HEX BOLT	STEEL	3/8-16 X 2-3/4 (MCMaster-CARR #91247A635)	1
																B/O -103	2	HEX BOLT	STEEL	7/16-14 X 2-3/4 (MCMaster-CARR #91247A680)	1
																B/O -105	1	CLEVIS PIN	STEEL	Ø3/4 X 2-1/2 USABLE (MCMaster-CARR #98306A560)	1
																B/O -109	4	B.H. SOCKET HEAD CAP SCREW	STEEL	3/8-16 X 5/8 (MCMaster-CARR #91255A621)	1
																B/O -111	1	CLEVIS PIN	STEEL	Ø1/2 X 1-1/2 USABLE (MCMaster-CARR #98306A385)	1
																B/O -115	1	HEX BOLT	STEEL	1/2-13 X 1-1/4 (MCMaster-CARR #92865A714)	1
																B/O -117	1	CLEVIS PIN	STEEL	Ø3/8 X 2-1/2 USABLE (MCMaster-CARR #98306A283)	1
																B/O -119	2	CLEVIS PIN	STEEL	Ø3/8 X 1-1/2 USABLE (MCMaster-CARR #98306A275)	1
																B/O -123	3	HAIRPIN	STEEL	FOR Ø3/8 CLEVIS PIN (MCMaster-CARR #98335A049)	1
																B/O -125	2	CLEVIS PIN	STEEL	Ø7/16 X 2 USABLE (MCMaster-CARR #98306A334)	1
																B/O -127	6	HAIRPIN	STEEL	FOR Ø7/16 -3/4 CLEVIS PIN (MCMaster-CARR #98335A127)	1
																B/O -129	1	CLEVIS PIN	STEEL	Ø5/8 X 1-3/4 USABLE (MCMaster-CARR #98306A497)	1
																B/O -131	1	CLEVIS PIN	STEEL	Ø5/8 X 2-1/4 USABLE (MCMaster-CARR #98306A501)	1
																B/O -135	2	SWIVEL CASTER W/BRAKE		MSC #01507243	1
																B/O -137	2	RIGID CASTER		MSC #01507417	1
																B/O -139	16	B.H. SOCKET HEAD CAP SCREW	STEEL	5/16-18 X 3/8 (MCMaster-CARR #91255A576)	1
																B/O -141	16	LOCK WASHER	STEEL	Ø5/16 (MCMaster-CARR #91150A113)	1
																B/O -143	1	HYDRAULIC JACK		MSC #09050907	1
																B/O -145	1	HANDLE HYD. JACK	STEEL		1
																B/O -146	2	NO-SKID		GASKET SPECIALTIES 1.75 X 7.9	1
																B/O -147		WELD NUT	STEEL	1/2-13 UNC (MCMaster-CARR #93560A180)	14
																B/O -148	2	WELD NUT	STEEL	7/16-14 UNC (MCMaster-CARR #93975A350)	66
																B/O -149	4	WELD NUT	STEEL	3/8-16 UNC (MCMaster-CARR #90754A001)	66
																B/O -150	1	WASHER	STEEL	Ø1/2 (MCMaster-CARR #97744A265)	1
																B/O -151	4	RIVET	ALUMINUM	Ø1/8 X .275 (MCMaster-CARR #97447A015)	5
																B/O	1	DART PLACARD	ALUMINUM	RB41011	5
ASSY QTY -79	ASSY QTY -73L	ASSY QTY -73R	ASSY QTY -66	ASSY QTY -54	ASSY QTY -51	ASSY QTY -43	ASSY QTY -28	ASSY QTY -24	ASSY QTY -18	ASSY QTY -16	ASSY QTY -15	ASSY QTY -10	ASSY QTY -8	ASSY QTY -2							

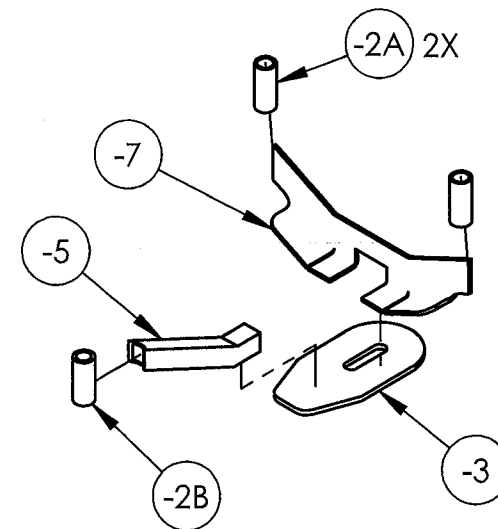
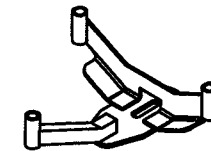
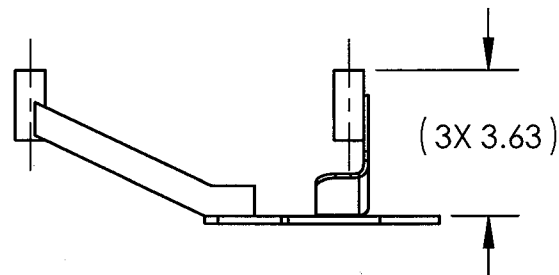
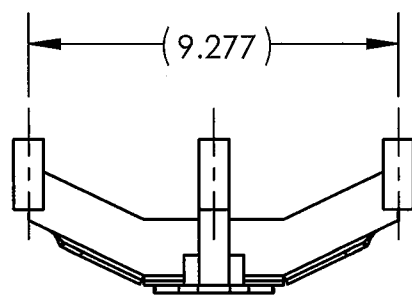
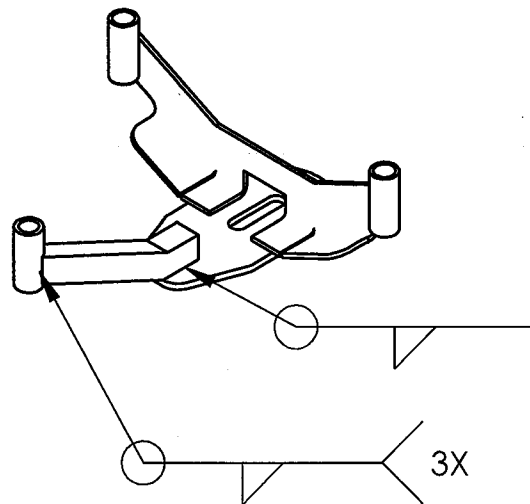
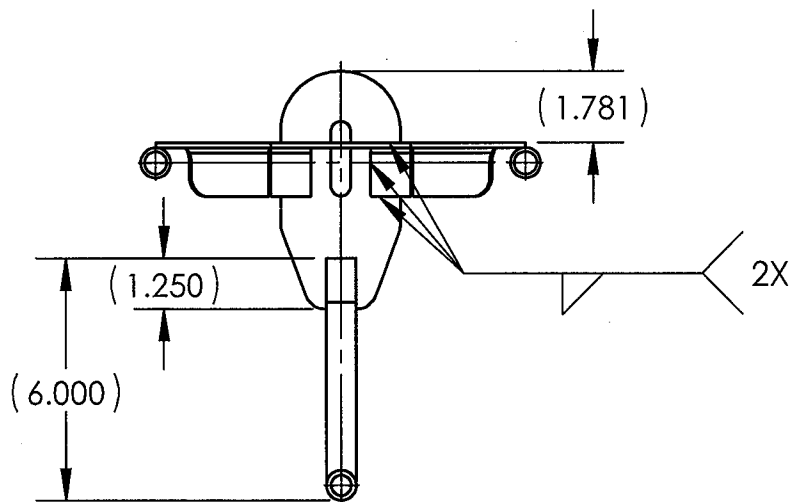
SEE ATTACHED DEVIATION



NOTES:
1) ENGRAVE THE TOOL P/N, S/N, AND "SWL: 550 LBS" ON THE DART PLACARD WHERE INDICATED

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625	REV L
MATERIAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°	
CHECKED BY: COLE	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
OPPS APPR: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: LINDSAY	USED ON MODEL
MD-500	
SCALE 1:16	DATE 11/07/2019
SHEET 6 OF 76	

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NOTE:
USE WELD FIXTURE RBT18625-2F TO POSITION FOR WELDING.

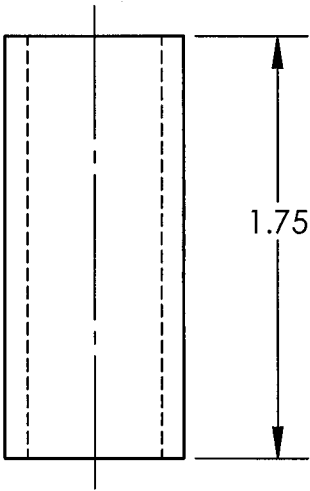
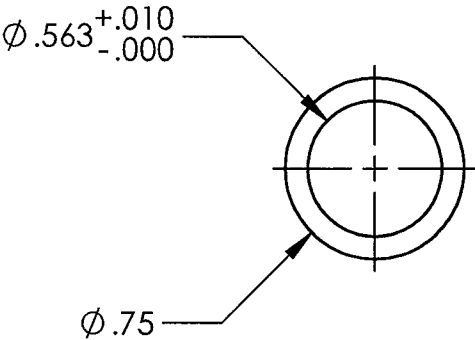
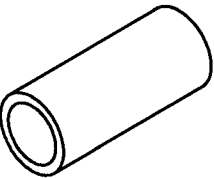
DART
AEROSPACE

TITLE		MD-500 ENGINE LIFT	
DWG NO.		RBT18625-2	REV L
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°		
HEAT TREAT			
FINISH			
SPEC			
DRAWN BY:	COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
CHECKED:	DUERFELDT		
OPPS APPR:	ANDERSON		
QA APPR:	LINDSAY		
APPROVED:		USED ON MODEL MD-500	
SCALE	1:6	DATE	11/07/2019
		SHEET 7 OF 76	

② SEE ATTACHED DEVIATION

TRANSMISSION ADAPTER

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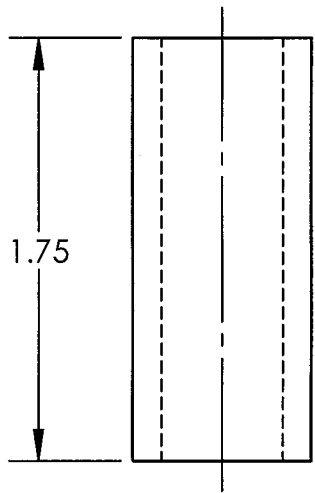
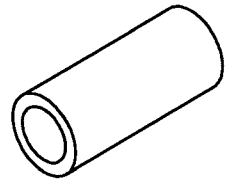
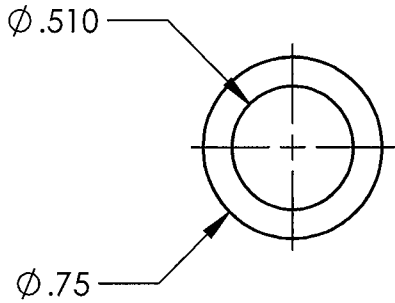


SEE ATTACHED DEVIATION

ATTACH TUBE

TITLE MD-500 ENGINE LIFT			
DWG NO. RBT18625-2A			REV L
MAT'L CDS		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -2		.XXX \pm .005 FRACTIONS \pm 1/8	
SPEC		.XX \pm .01 ANGLES \pm 5°	
DRAWN BY: COLE		.X \pm .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 11/07/2019		USED ON MODEL	
SHEET 8 OF 76		MD-500	

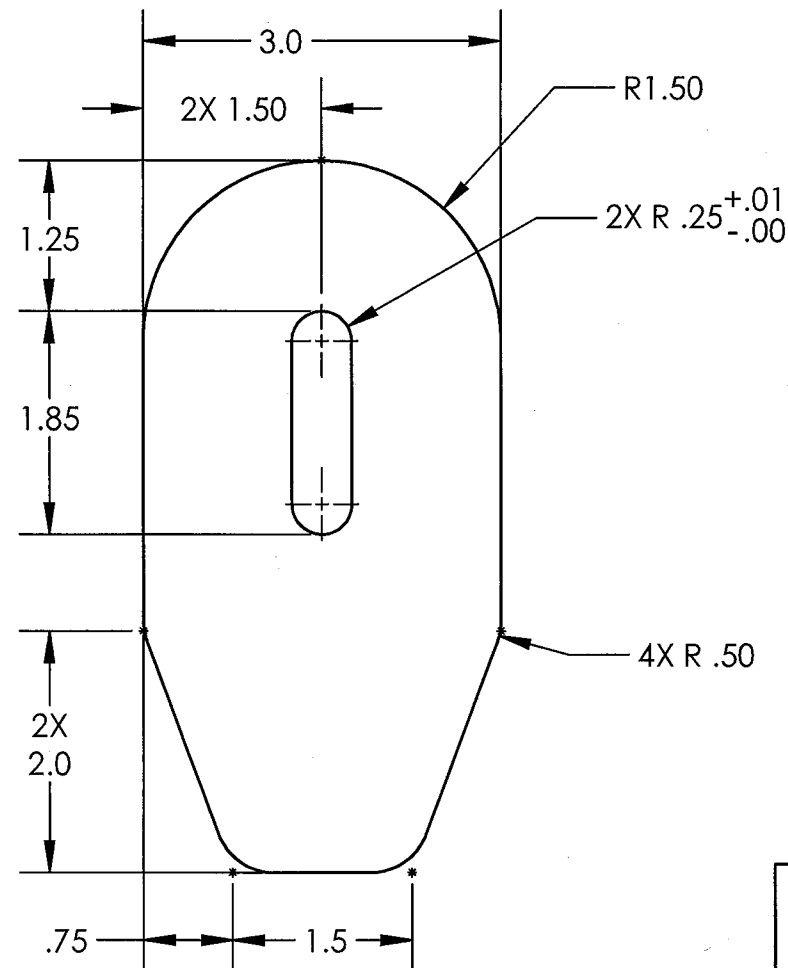
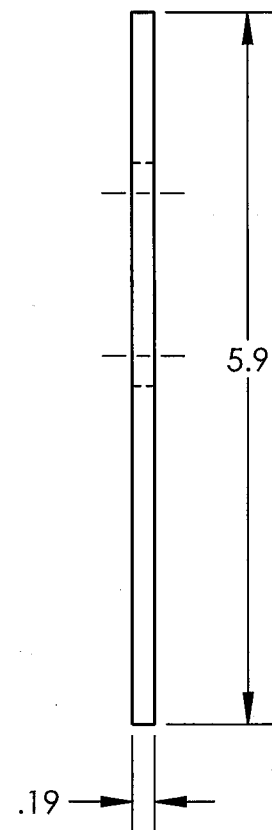
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(-2B) **SEE ATTACHED DEVIATION**
ATTACH TUBE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-2B	REV L
MAT'L CDS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -2	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 9 OF 76

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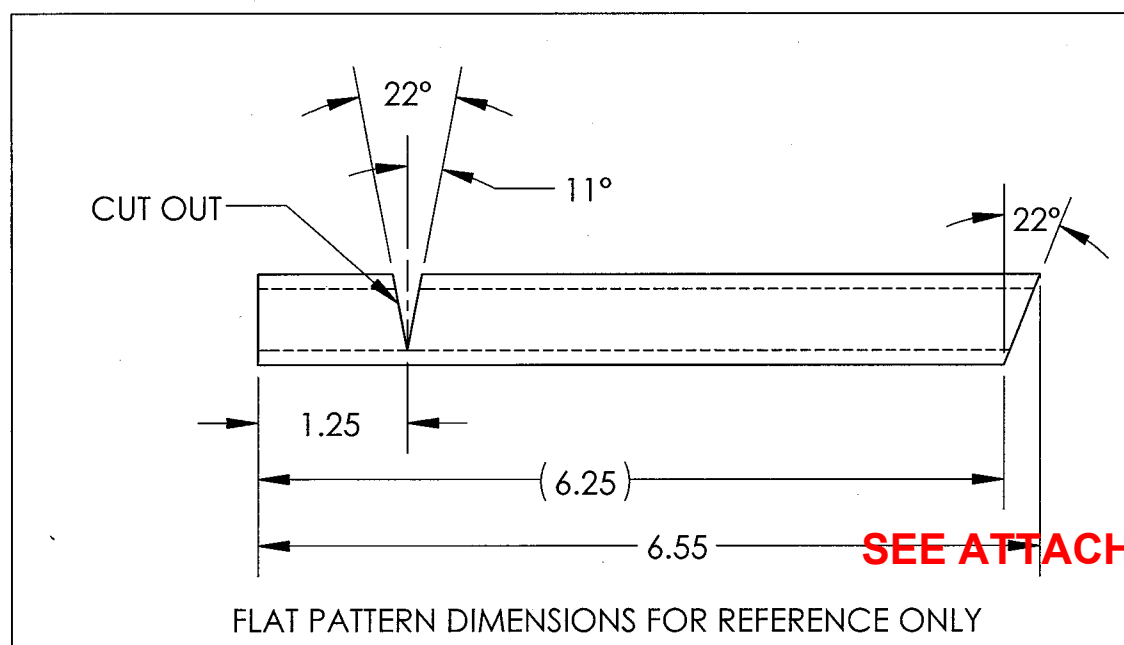
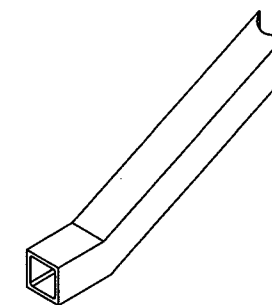
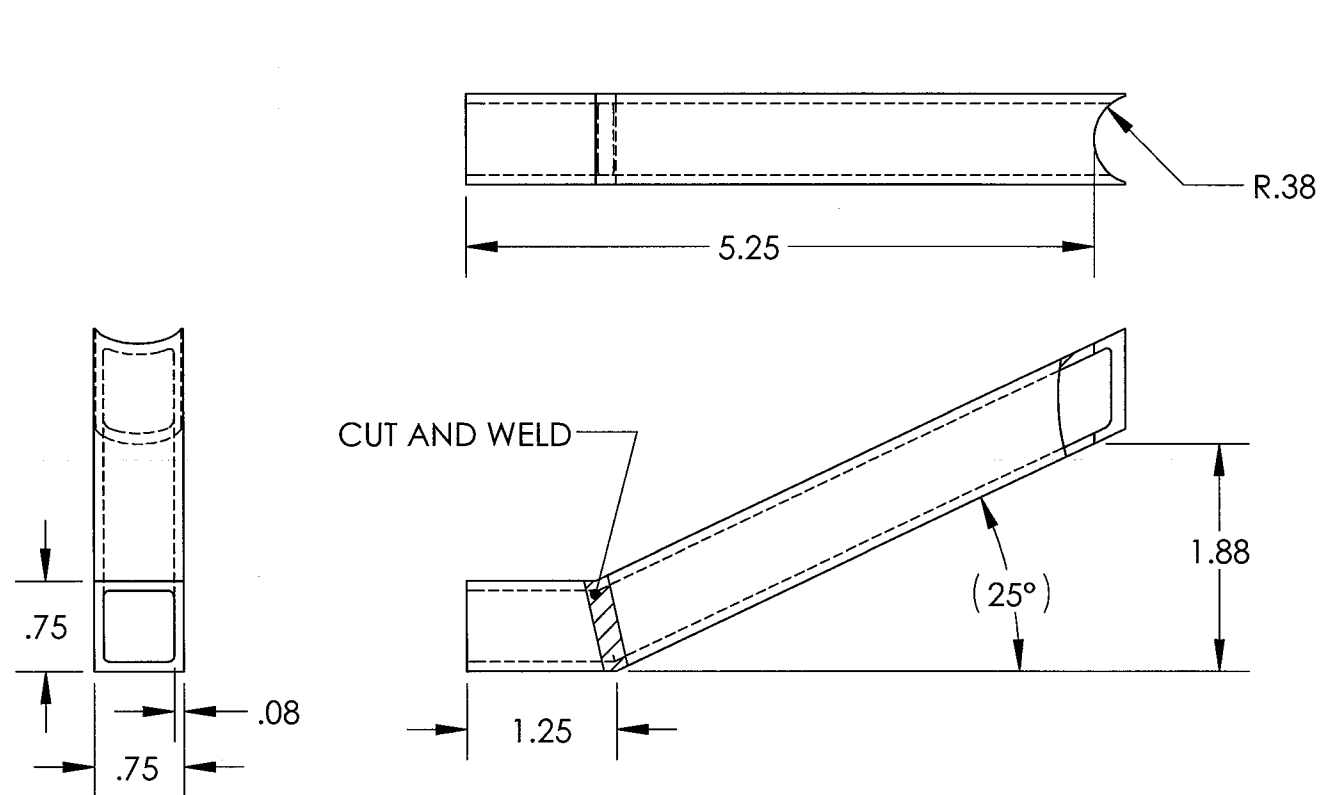


③ SEE ATTACHED DEVIATION

ATTACH PLATE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-3	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -2	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 10 OF 76	

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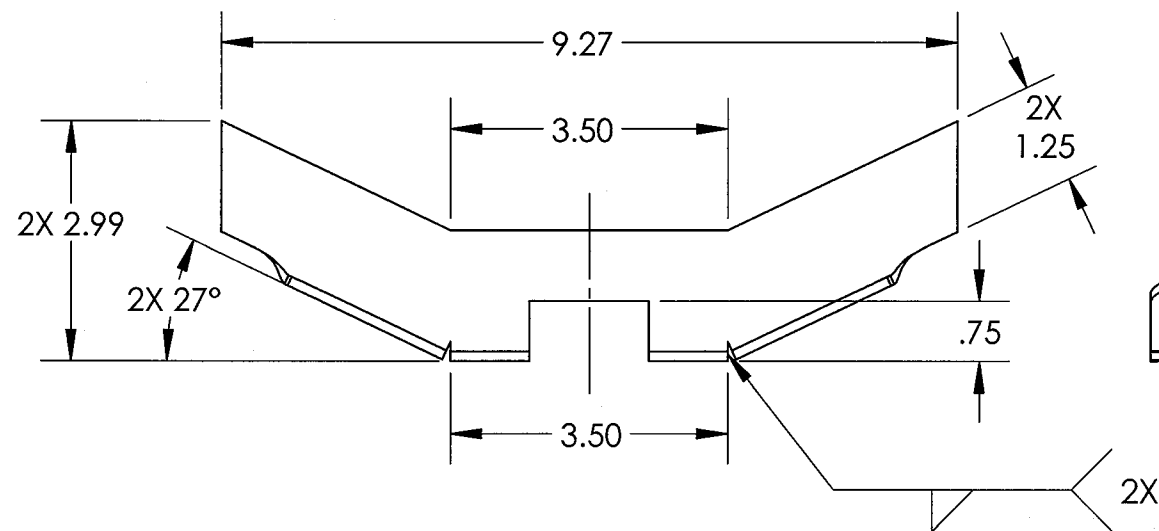
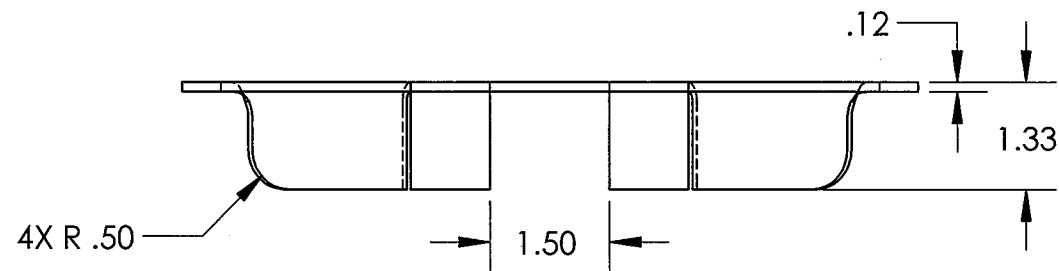


SEE ATTACHED DEVIATION

BRACKET

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-5	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH SEE -2	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY: COLE	.X ± .1 SURFACES = 125/
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED:	USED ON MODEL MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 11 OF 76	

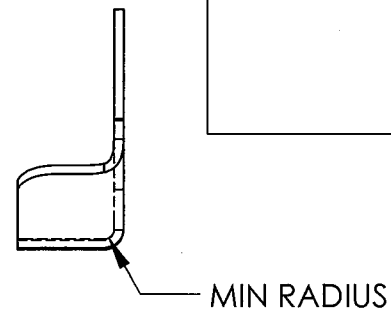
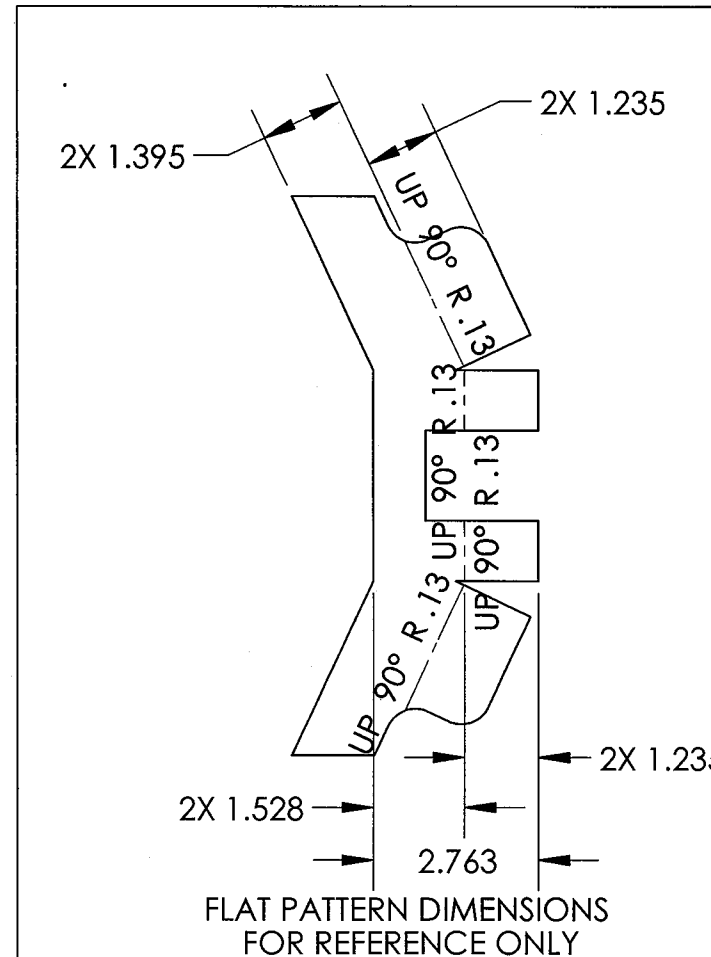
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(-7)

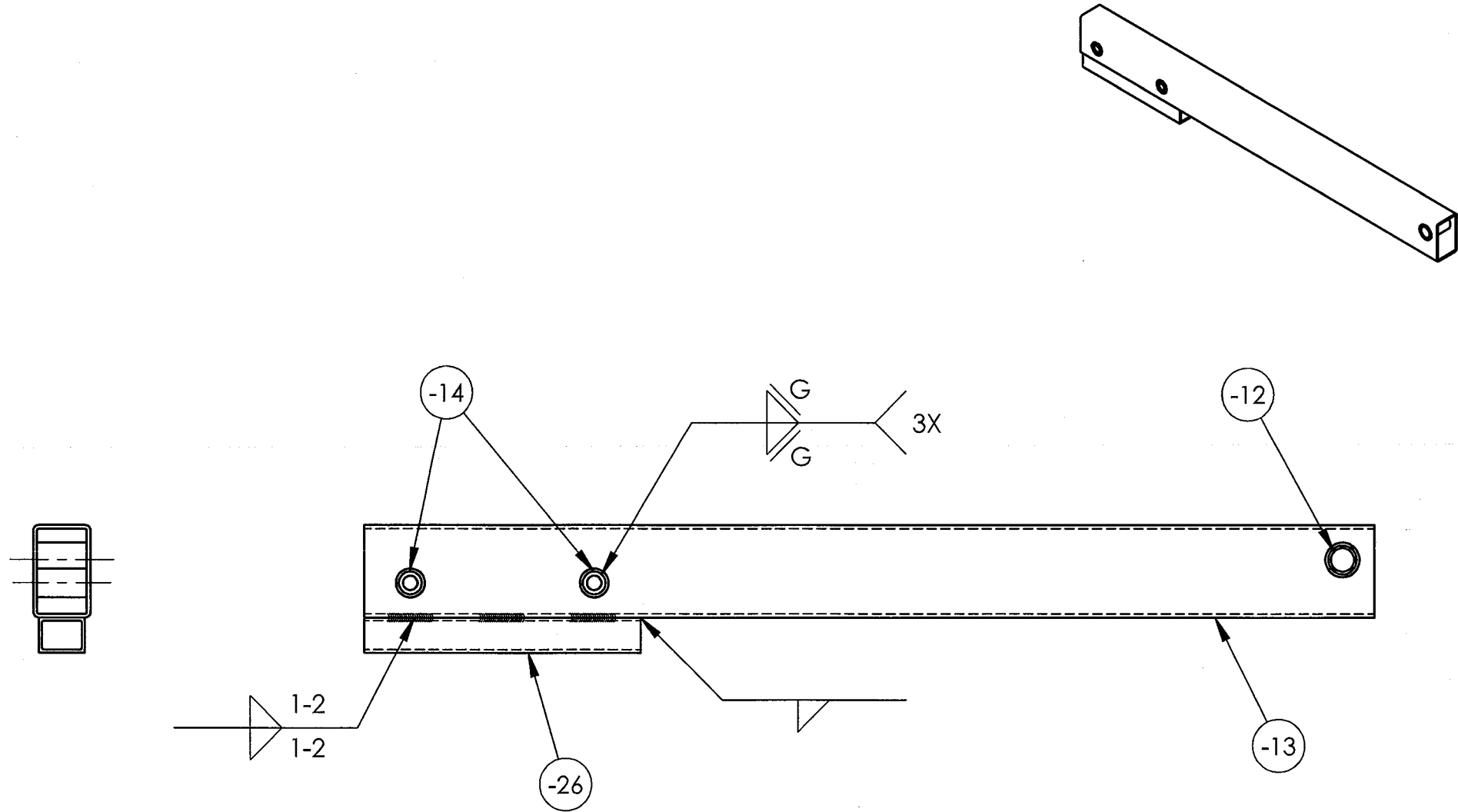
WING BRACKET

SEE ATTACHED DEVIATION



DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-7	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -2	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:3	DATE 11/07/2019
SHEET 12 OF 76	

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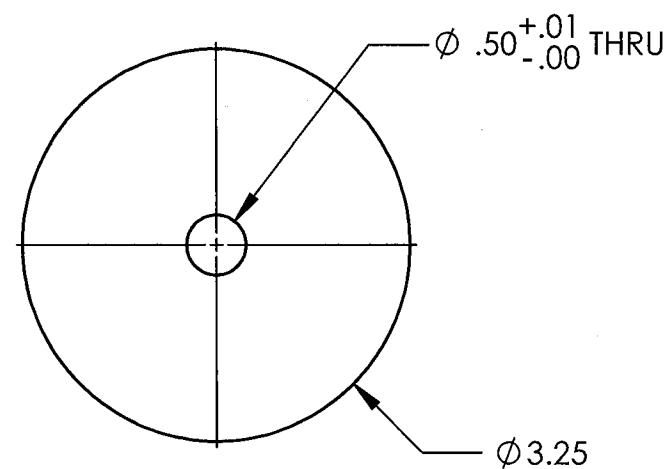
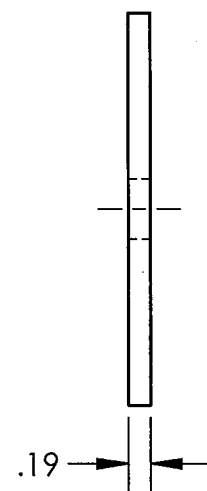
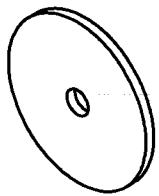


SEE ATTACHED DEVIATION

TRANSMISSION ADAPTER TUBE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-8	REV L
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:4	DATE 11/07/2019
SHEET 13 OF 76	

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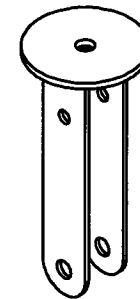
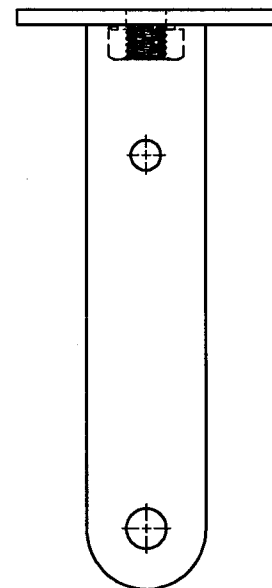
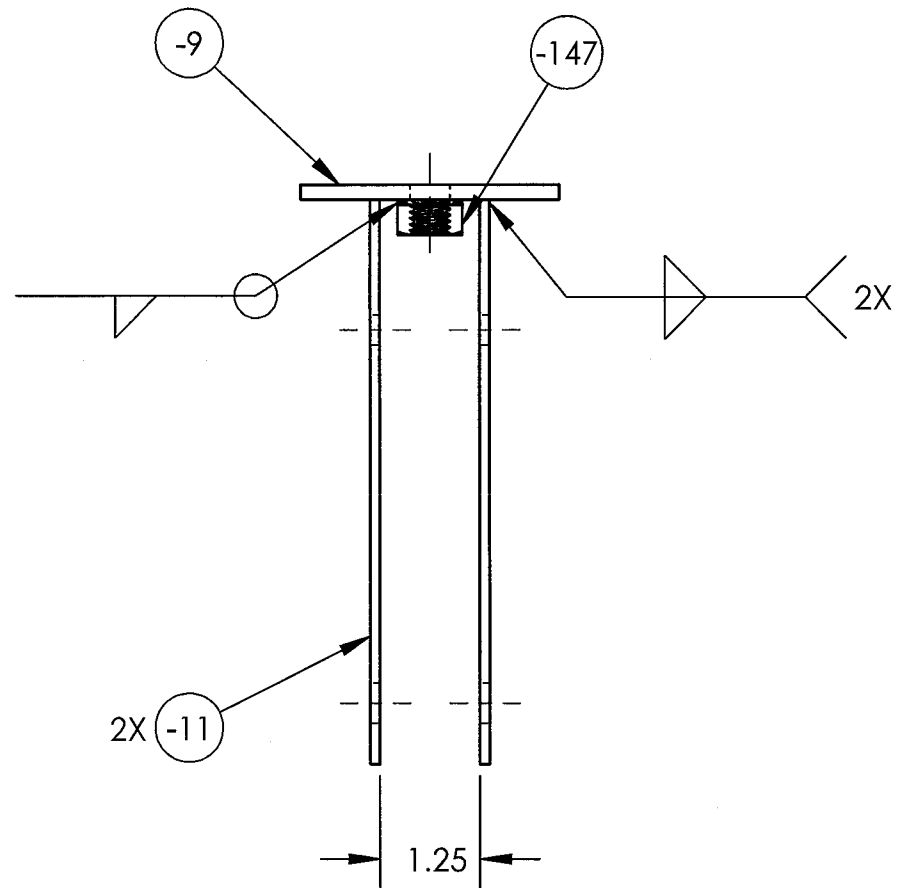


⑨ SEE ATTACHED DEVIATION

DISK

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-9	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH SEE -10	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD-500
APPROVED:	
SCALE 1:2	DATE 11/07/2019 SHEET 14 OF 76

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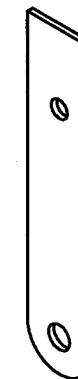
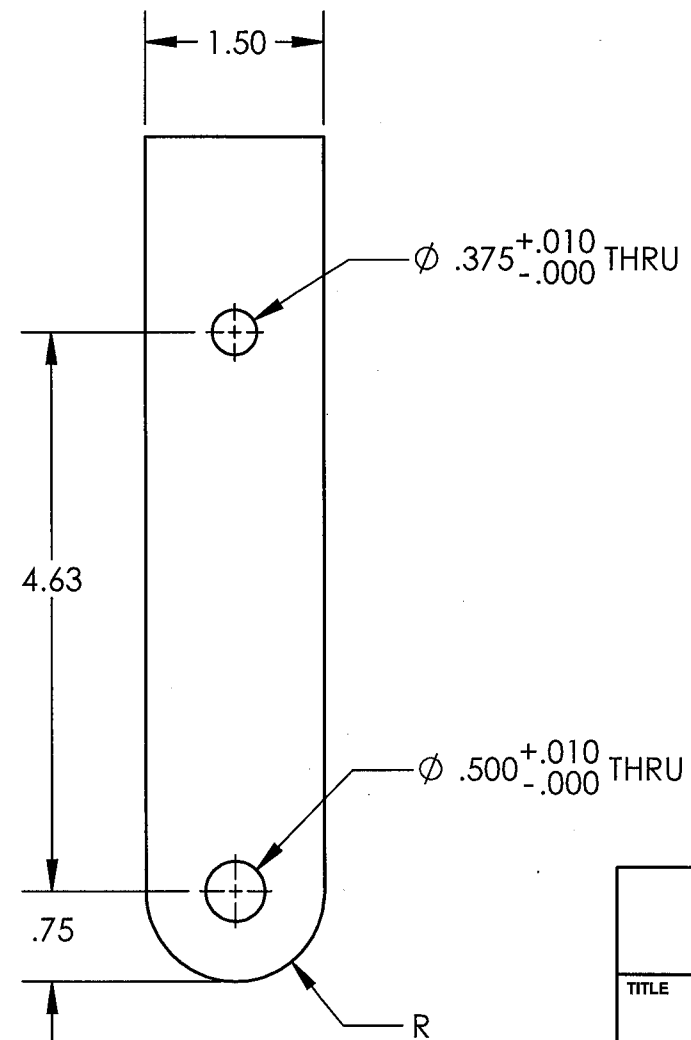
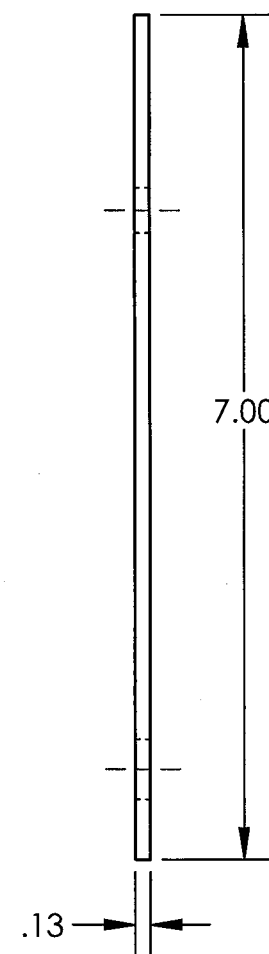


(-10) SEE ATTACHED DEVIATION

TRANSMISSION ADAPTER PIVOT

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-10	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	MD-500
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: [Signature]	
SCALE 1:3	DATE 11/07/2019 SHEET 15 OF 76

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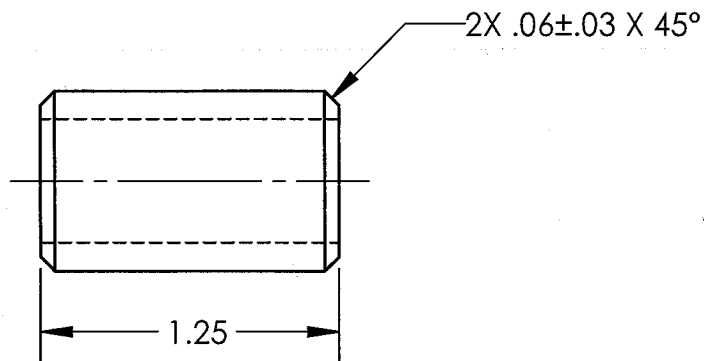
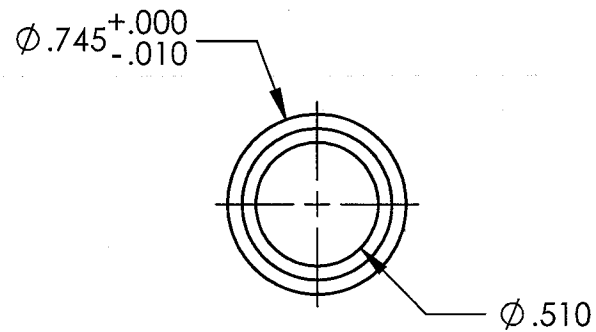
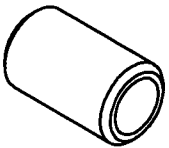


SEE ATTACHED DEVIATION

STRAP

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-11	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -10	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 16 OF 76	

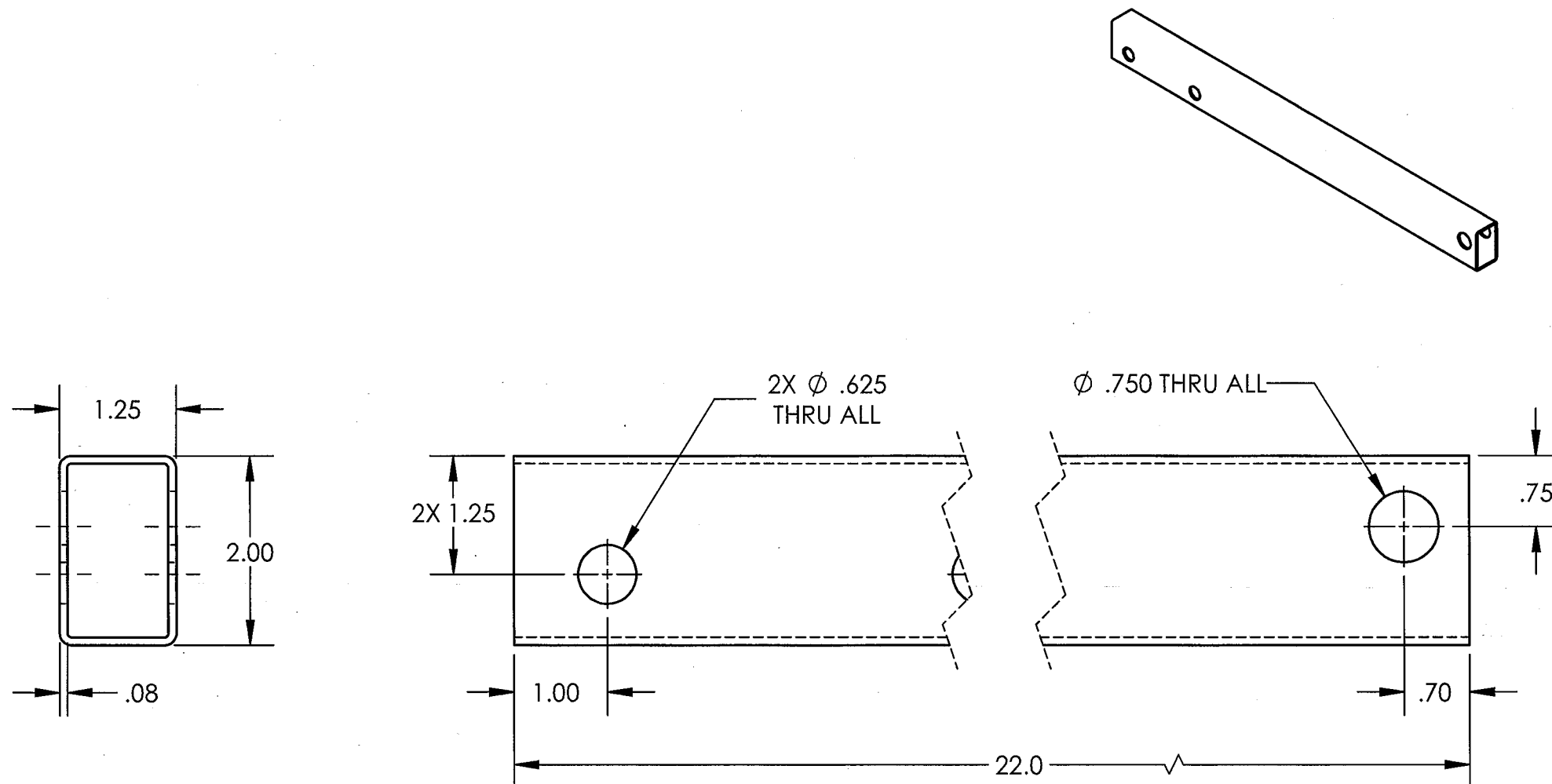
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(-12) **SEE ATTACHED DEVIATION**
BUSHING

TITLE MD-500 ENGINE LIFT			
DWG NO. RBT18625-12			REV L
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -8		.XXX \pm .005 FRACTIONS \pm 1/8	
SPEC		.XX \pm .01 ANGLES \pm .5°	
DRAWN BY: COLE		.X \pm .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 11/07/2019		USED ON MODEL	
SHEET 17 OF 76		MD-500	

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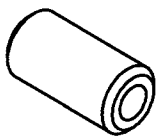
SEE ATTACHED DEVIATION

-13

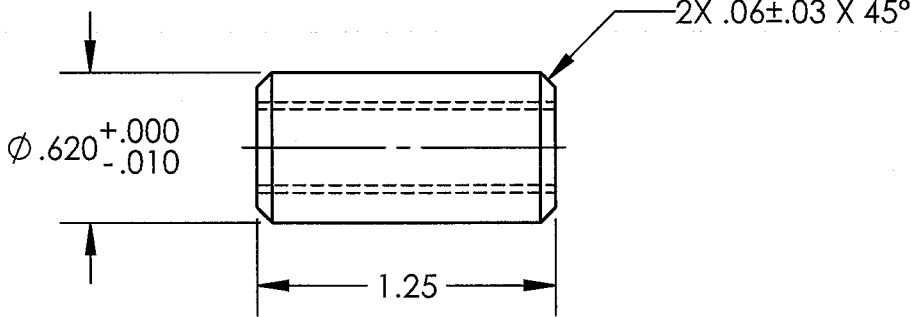
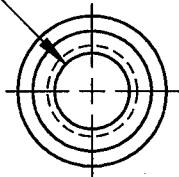
ADAPTER TUBE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-13	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -8	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 18 OF 76	

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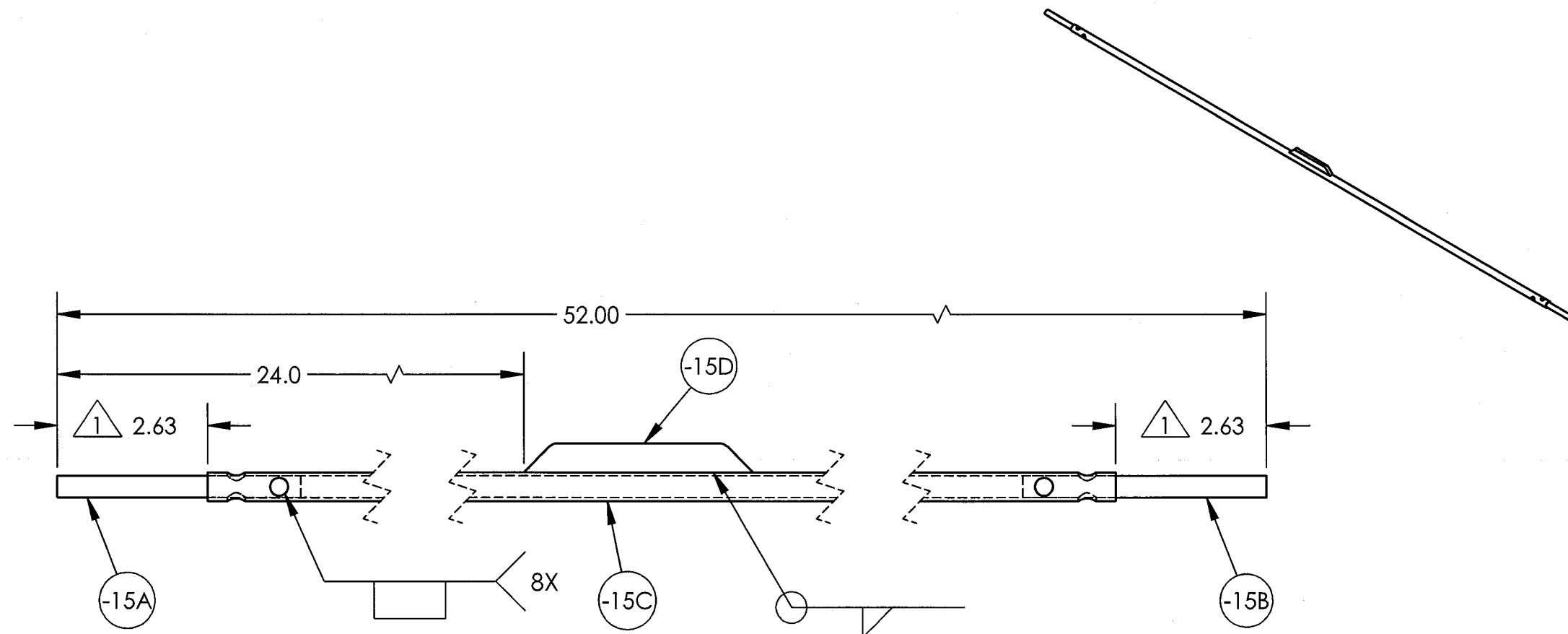
3/8-16 UNC - 2B
THRU ALL



(-14) **SEE ATTACHED DEVIATION**
THREADED BUSHING

TITLE MD-500 ENGINE LIFT			
DWG NO. RBT18625-14			REV L
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH SEE -8 & -28		.XX ± .01 ANGLES ± .5°	
SPEC		.X ± .1 SURFACES = 125/	
DRAWN BY: COLE		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED:		MD-500	
SCALE 1:1	DATE 11/07/2019	SHEET 19 OF 76	

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NOTE:

1 MASK THREADS PRIOR TO POWDER COATING.

DART
AEROSPACE

TITLE
MD-500 ENGINE LIFT

DWG NO. RBT18625-15 REV L

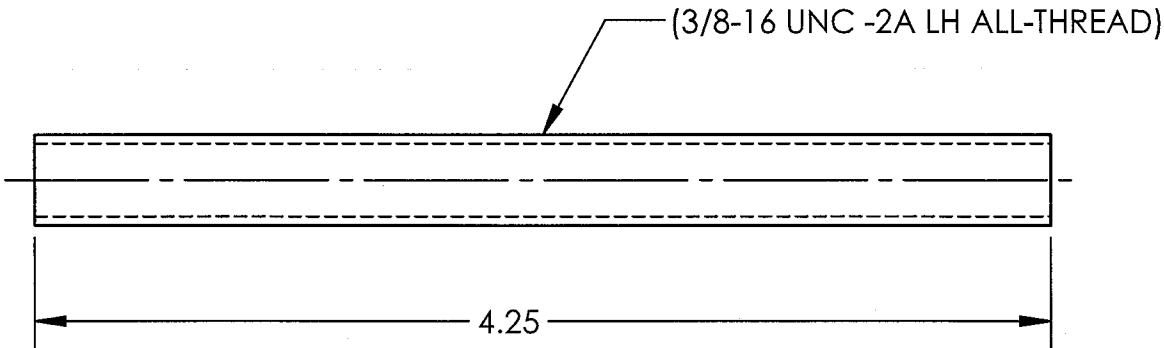
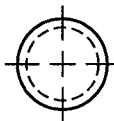
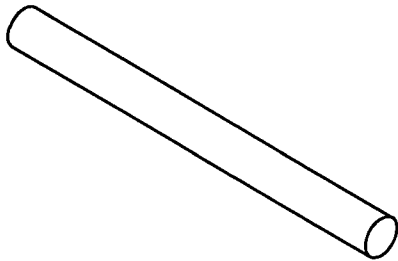
MAT'L
FINISH POWDER COAT BLACK
SPEC
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
.X ± .1 SURFACES = 125

DRAWN BY: COLE
CHECKED: DUERFELDT
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: [Signature]
SCALE 1:3 DATE 11/07/2019 SHEET 20 OF 76

-15 SEE ATTACHED DEVIATION

TIE-ROD ASSEMBLY

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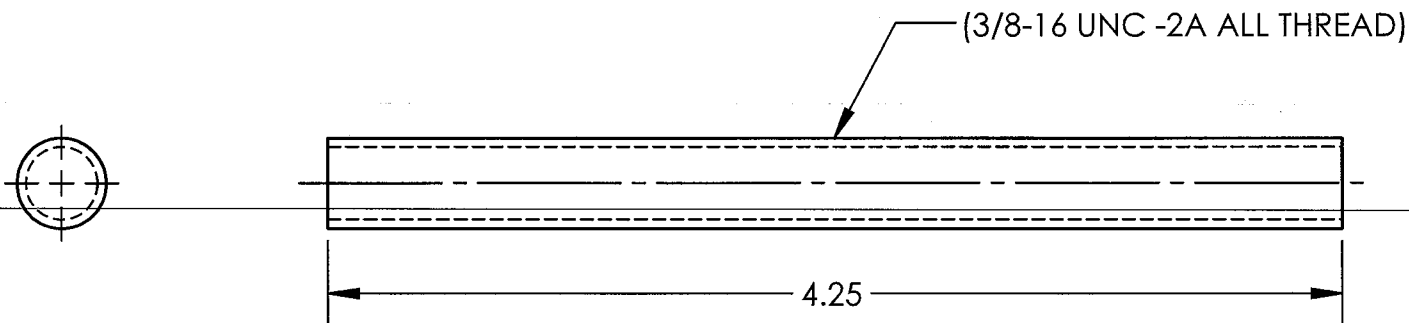
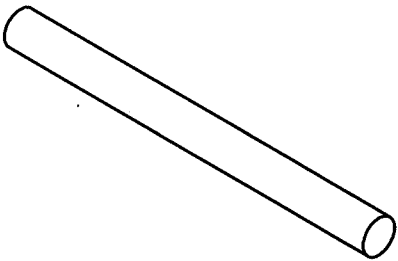


SEE ATTACHED DEVIATION

LH THREAD

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-15A	REV L
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -15	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 21 OF 76

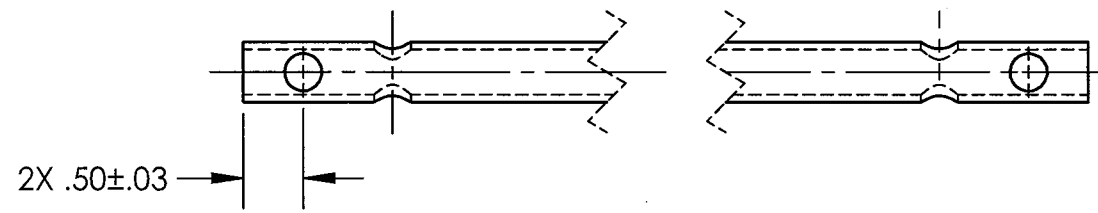
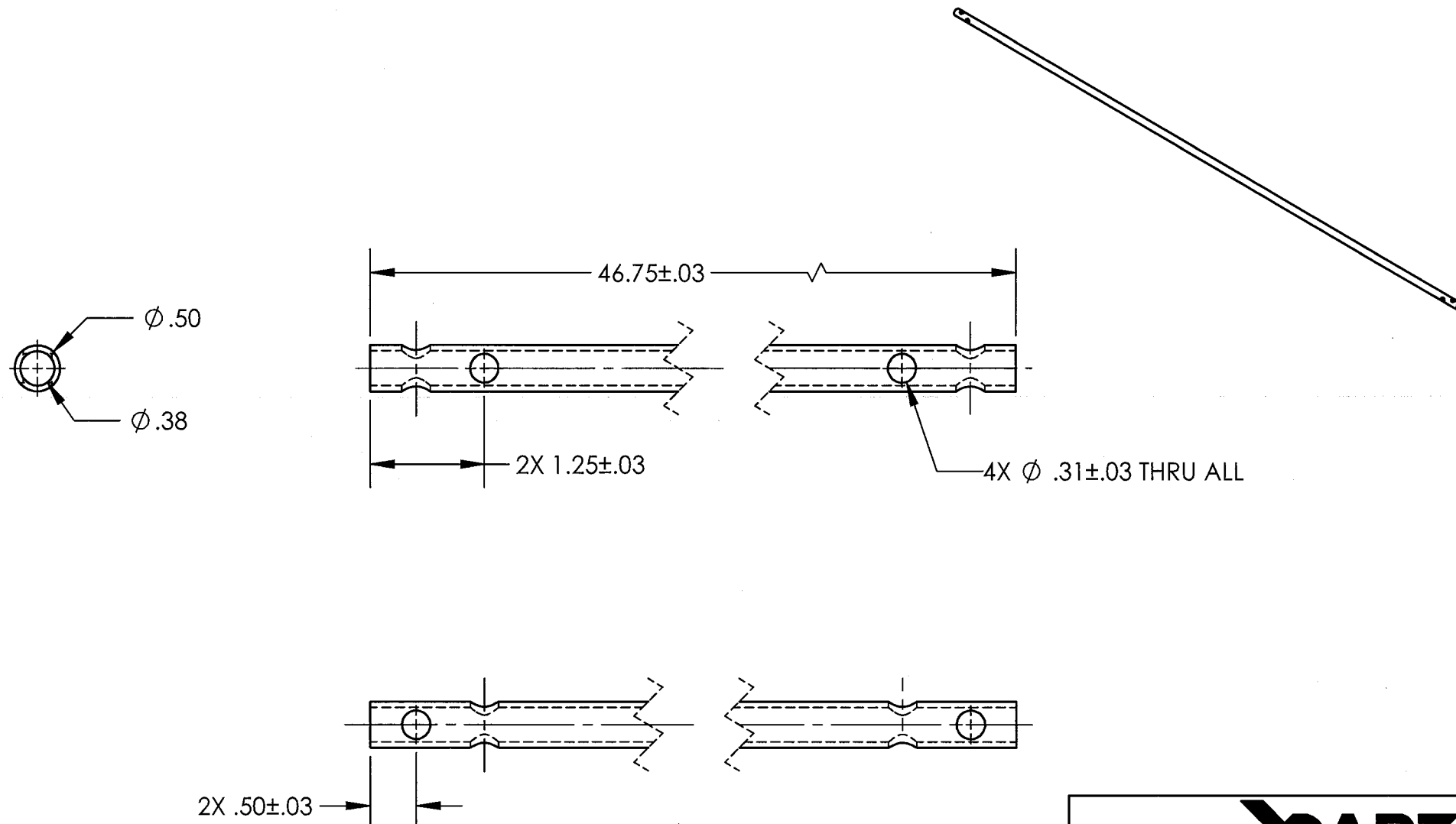
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(-15B) SEE ATTACHED DEVIATION
RH THREAD

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-15B	REV L
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -15	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 22 OF 76

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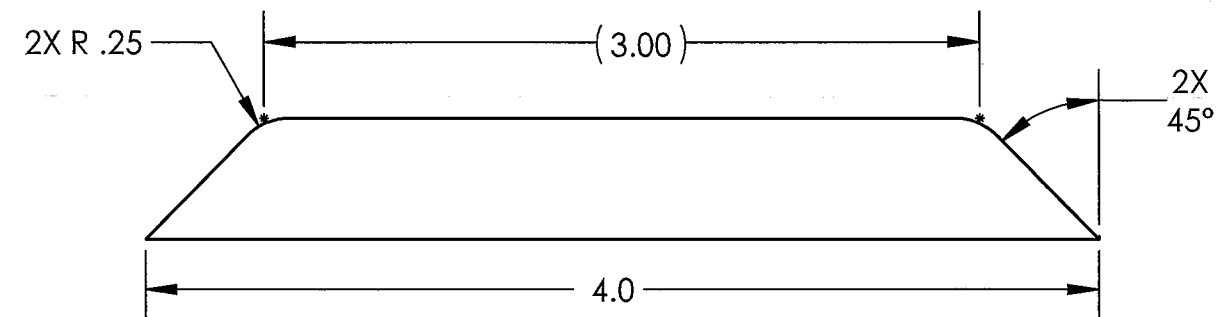
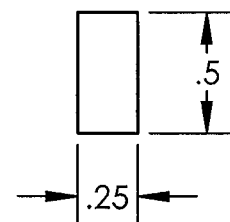
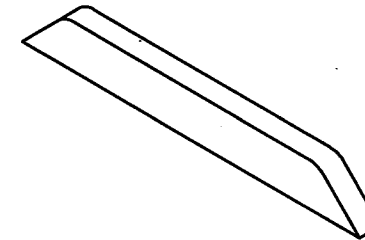


SEE ATTACHED DEVIATION

TIE-ROD TUBE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-15C	REV L
MAT'L CDS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -15	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm .5°
DRAWN BY: COLE	.X \pm .1 SURFACES = 125/
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED:	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 11/07/2019	USED ON MODEL
SHEET 23 OF 76	MD-500

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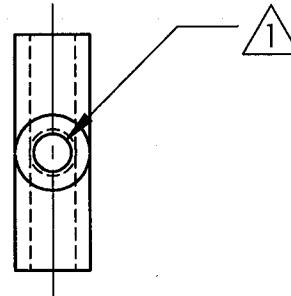
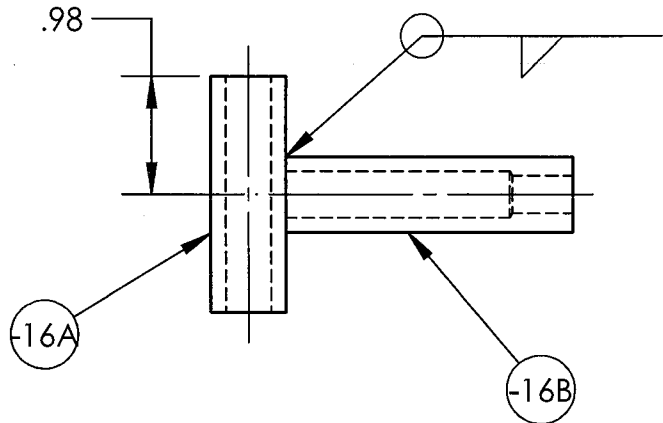
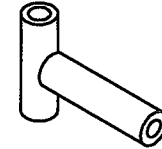
-15D

TAB

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-15D	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -15	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019
SHEET 24 OF 76	

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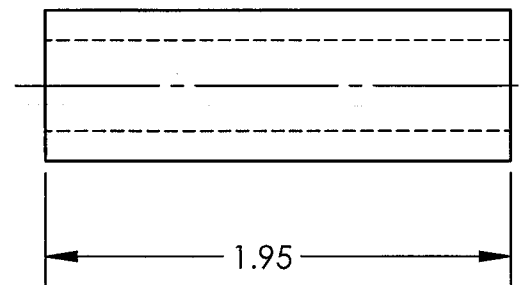
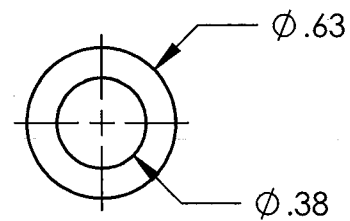
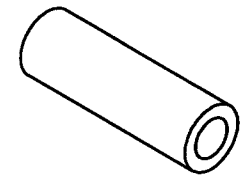


NOTE:
1 MASK THREADS PRIOR TO POWDER COATING.

SEE ATTACHED DEVIATION
LH BUSHING ASSEMBLY

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-16	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	MD-500
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED:	
SCALE 1:2	DATE 11/07/2019 SHEET 25 OF 76

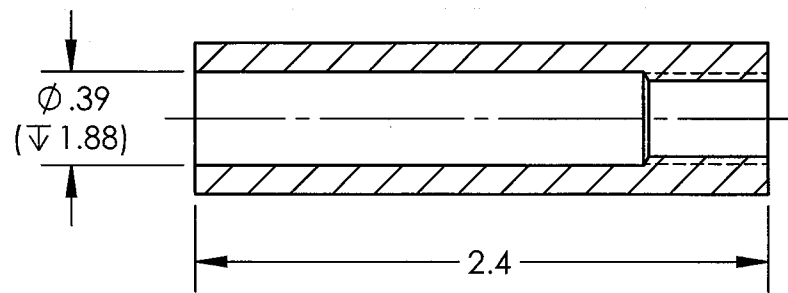
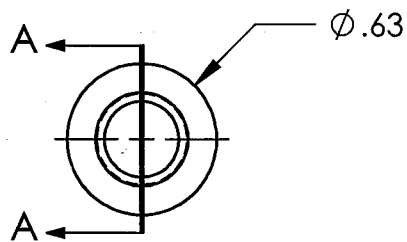
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-16A
EYE
SEE ATTACHED DEVIATION

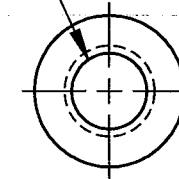
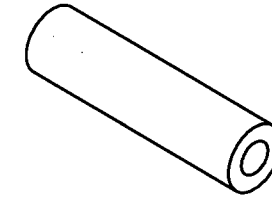
DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-16A	REV L
MAT'L CDS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -16	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 26 OF 76	

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SECTION A-A

3/8-16 UNC -2B LH ∇ .50

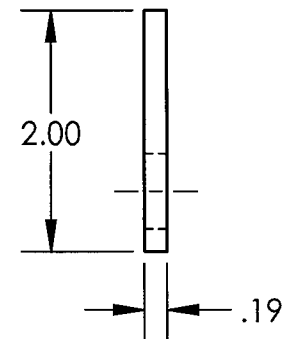
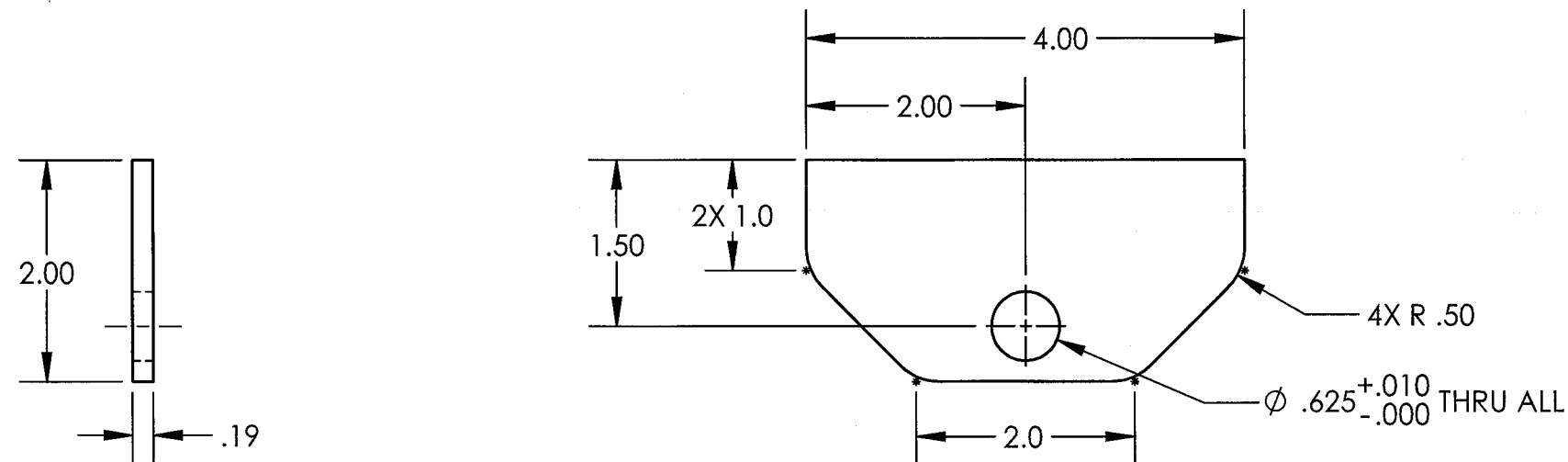
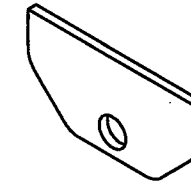


SEE ATTACHED DEVIATION

LH THREAD BUSHING

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-16B	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -16	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY: COLE	.X \pm .1 SURFACES = 125/✓
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSEY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED:	USED ON MODEL
SCALE 1:1	MD-500
DATE 11/07/2019	SHEET 27 OF 76

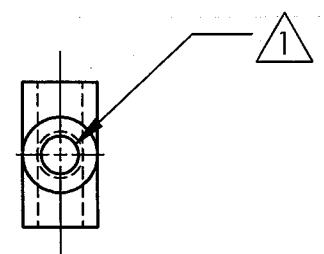
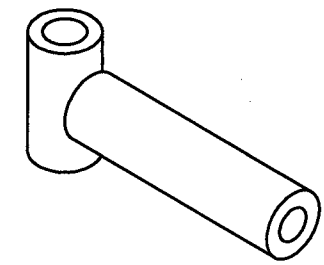
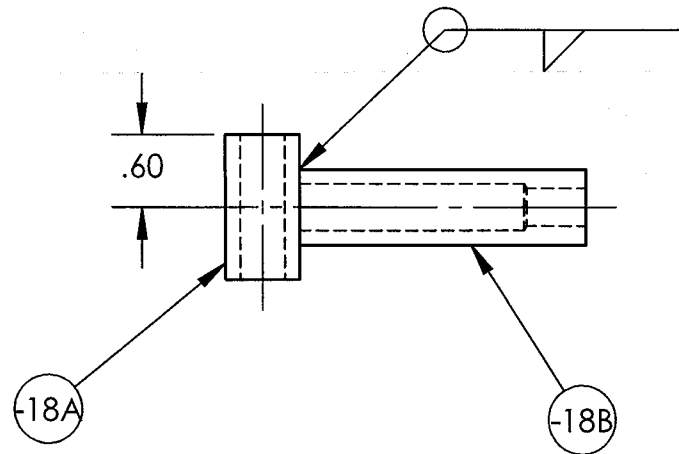
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(-17) SEE ATTACHED DEVIATION
RAM ATTACH

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-17	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH SEE -24	.XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD-500
APPROVED:	
SCALE 1:2	DATE 11/07/2019
SHEET 28 OF 76	

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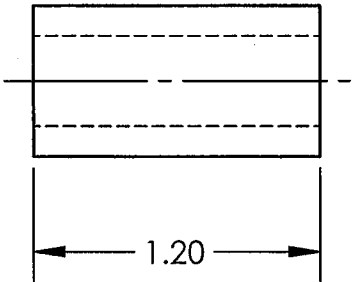
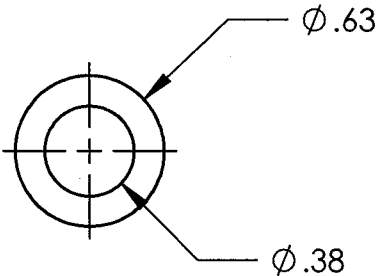
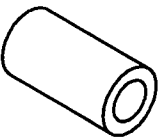
NOTE:
1 MASK THREADS PRIOR TO POWDER COATING.

SEE ATTACHED DEVIATION

RH BUSHING ASSEMBLY

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-18	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:2	DATE 11/07/2019 SHEET 29 OF 76

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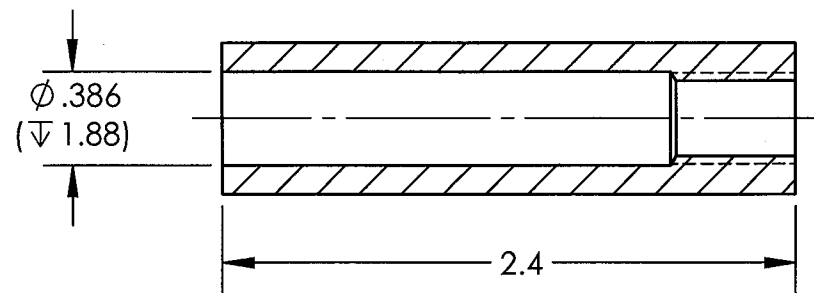
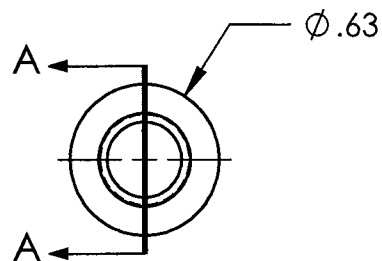
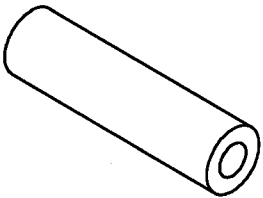
-18A

EYE

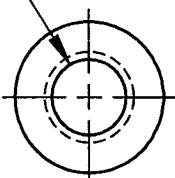
SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-18A	REV L
MAT'L CDS HEAT TREAT FINISH SEE -18 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 30 OF 76

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3/8-16 UNC -2B ∇ .50



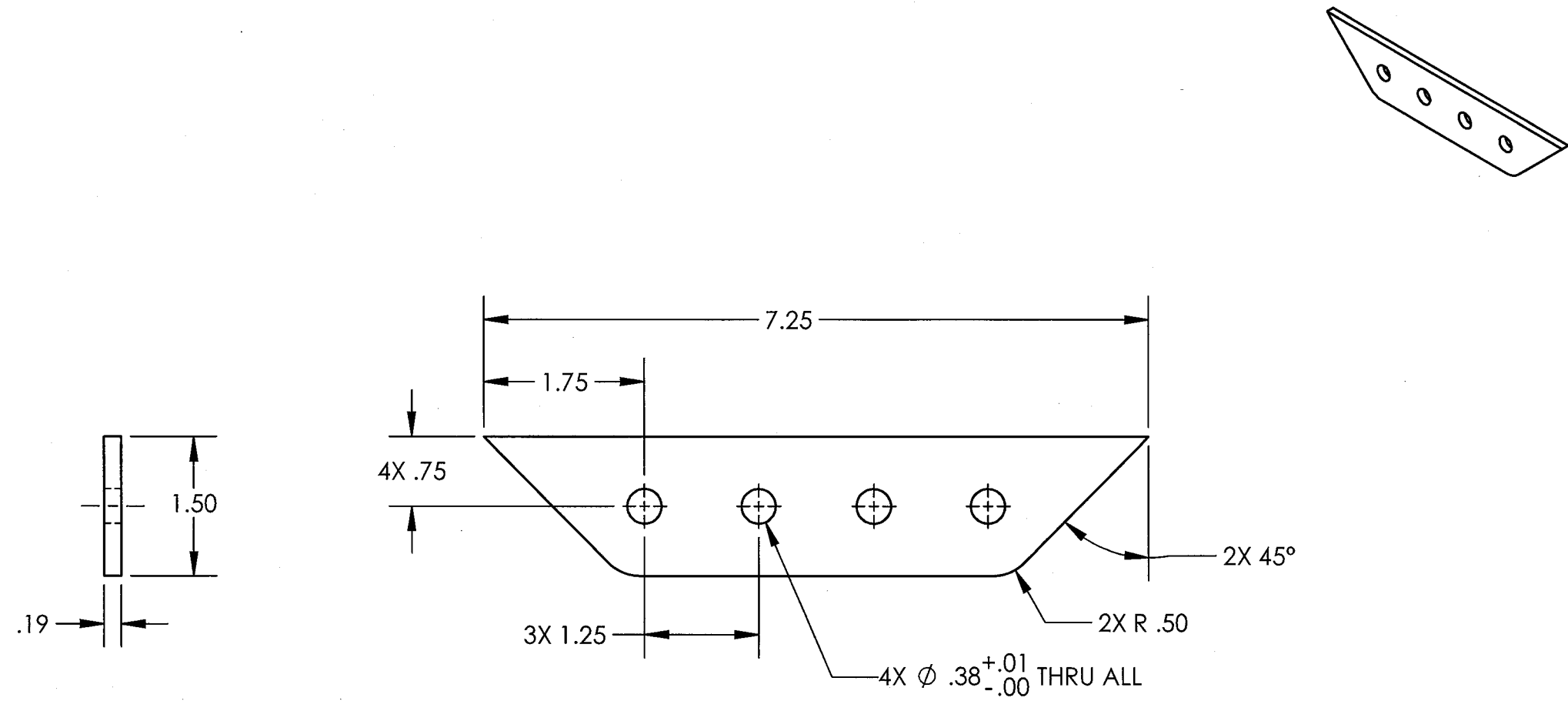
SECTION A-A

(-18B) SEE ATTACHED DEVIATION

RH THREAD BUSHING

TITLE MD-500 ENGINE LIFT			
DWG NO. RBT18625-18B			REV L
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX \pm .005 FRACTIONS \pm 1/8	
FINISH SEE -18		.XX \pm .01 ANGLES \pm 5°	
SPEC		.X \pm .1 SURFACES = 125/	
DRAWN BY: COLE		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED:		MD-500	
SCALE 1:1	DATE 11/07/2019	SHEET 31 OF 76	

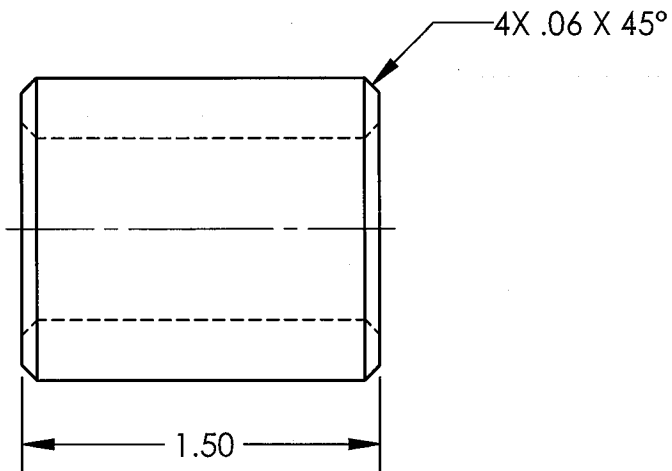
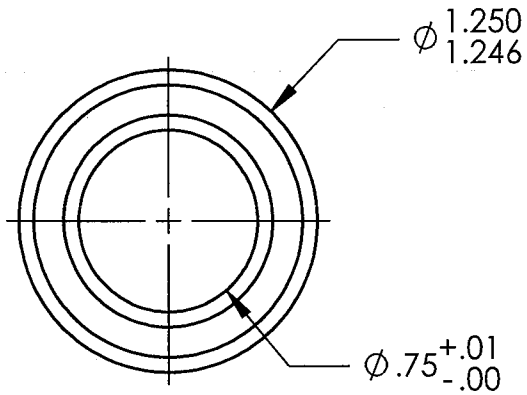
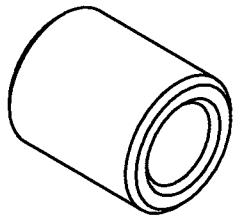
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(-19) SEE ATTACHED DEVIATION
TURNBUCKLE ATTACH

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-19	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -24	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 32 OF 76	

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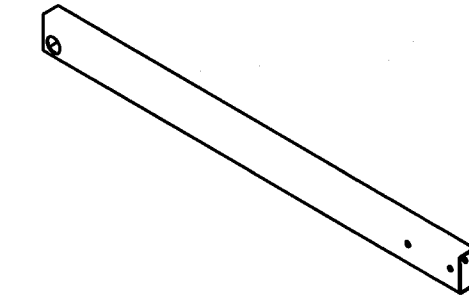
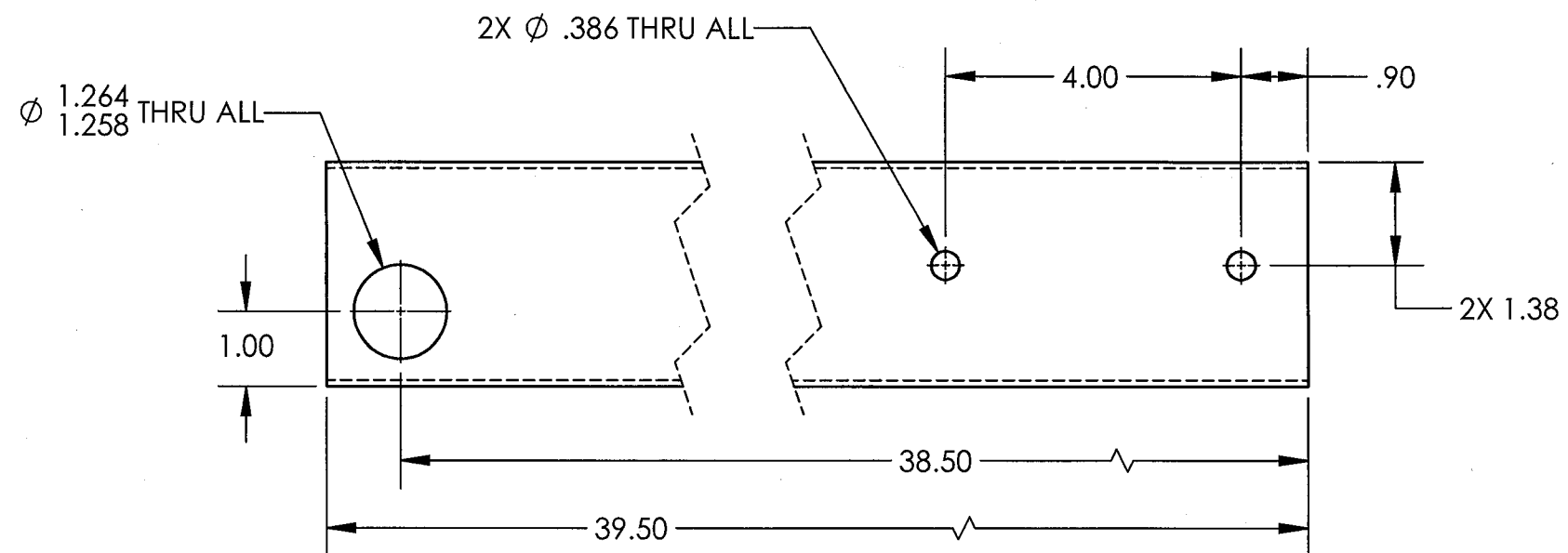
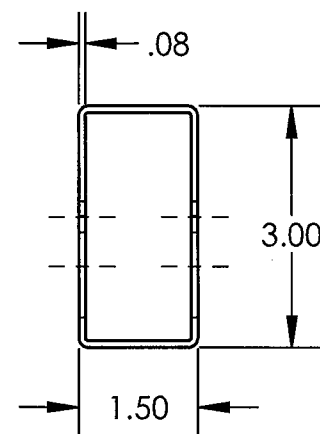
(-21)

SEE ATTACHED DEVIATION

BUSHING

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-21	REV L
MAT'L DOM HEAT TREAT FINISH SEE -24 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 33 OF 76

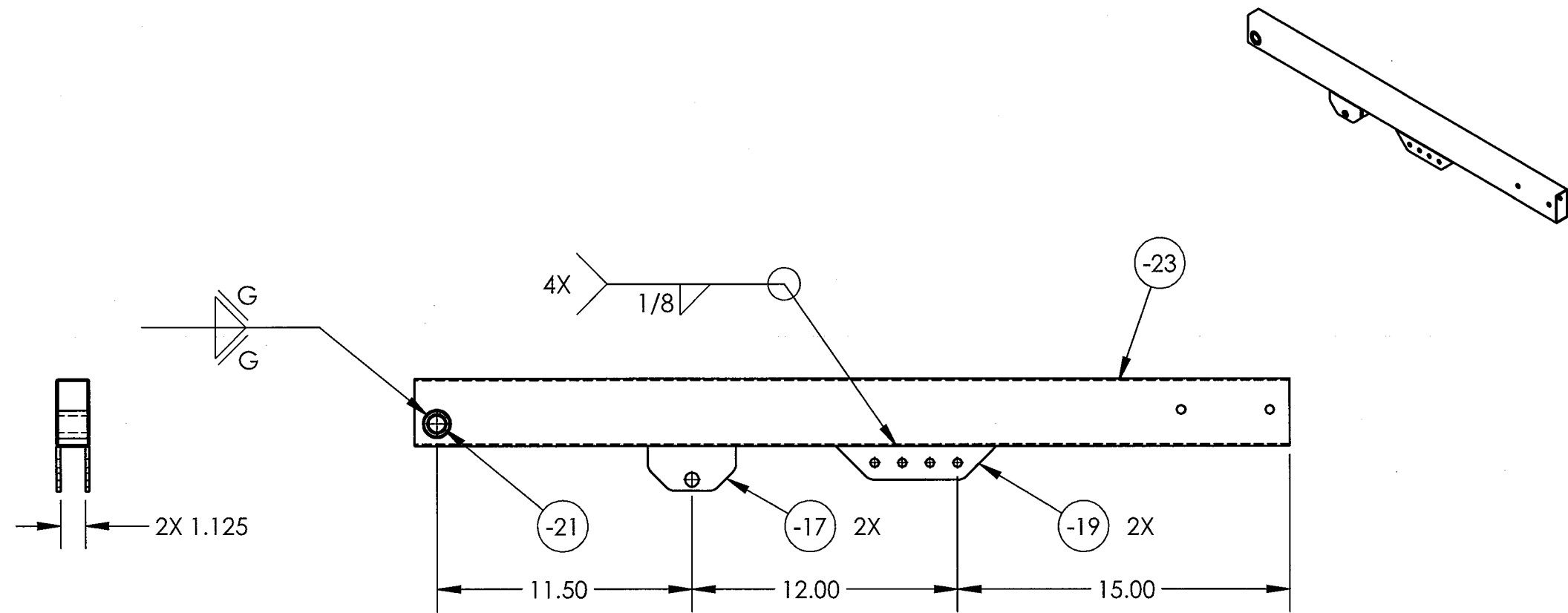
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(-23) SEE ATTACHED DEVIATION
BOOM

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-23	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT SEE -24	DIMENSIONS ARE IN INCHES
SPEC	.XXX ± .010 FRACTIONS ± 1/8
	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: [Signature]	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:3	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 34 OF 76	

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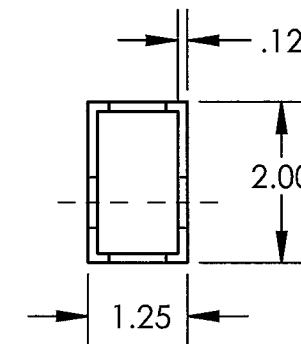
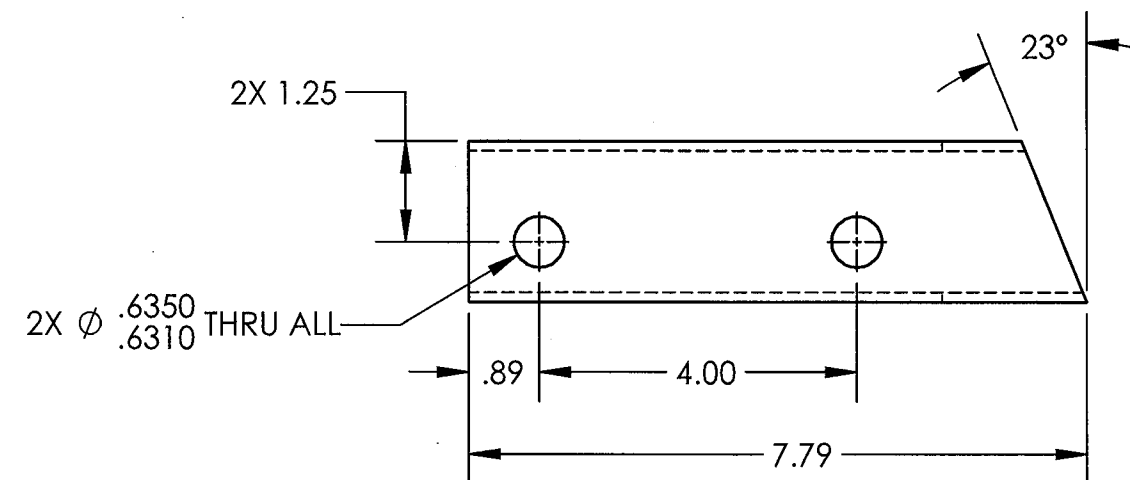
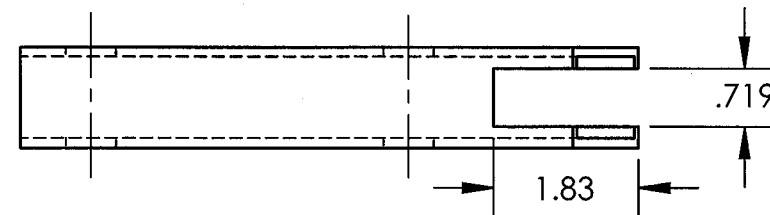
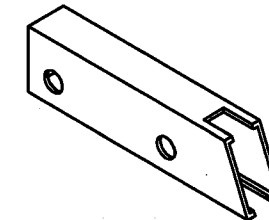


(-24)
BOOM ASSEMBLY

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-24	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:8	DATE 11/07/2019
SHEET 35 OF 76	

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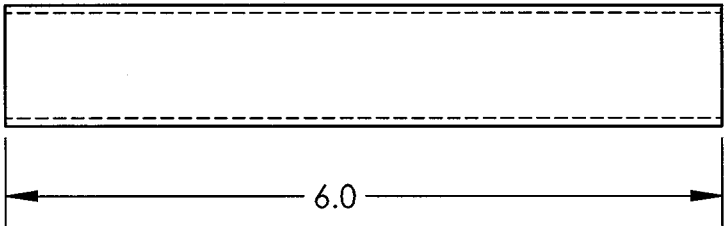
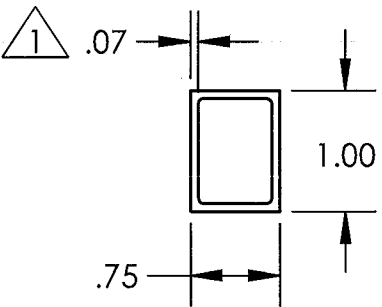
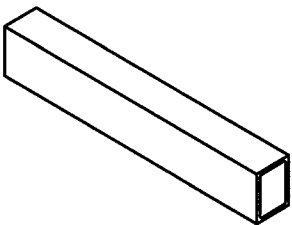


(-25) SEE ATTACHED DEVIATION

ENGINE ADAPTER TUBE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-25	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -28	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:3	DATE 11/07/2019 SHEET 36 OF 76

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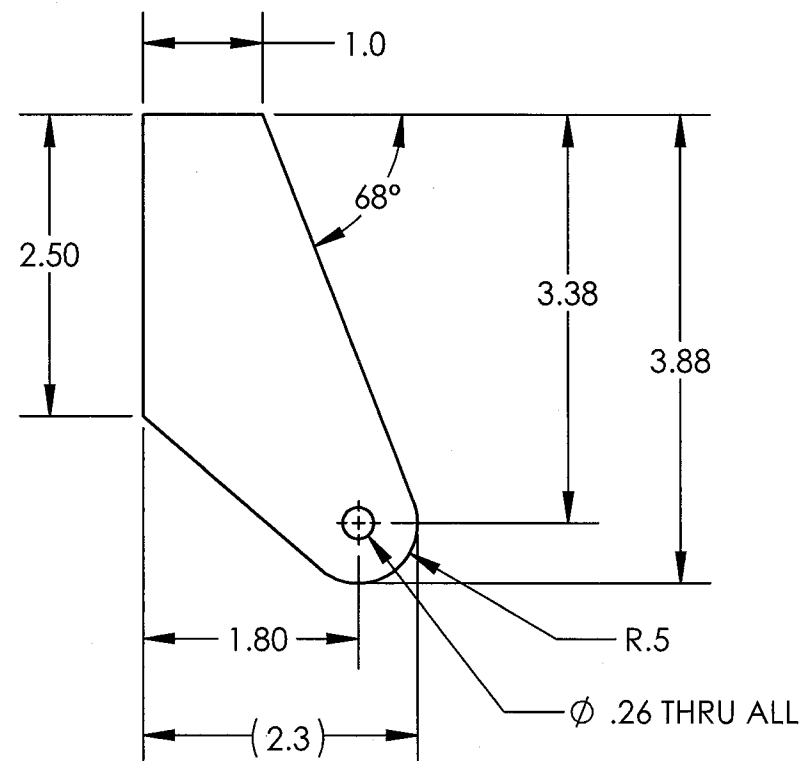
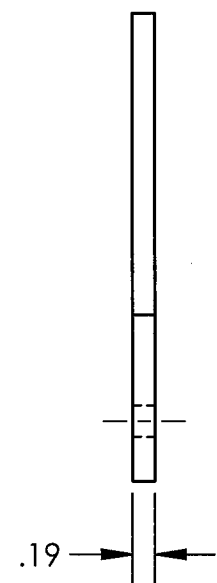


NOTE:
1 MAY BE SUBSTITUTED WITH .08 WALL THICKNESS.

-26 SEE ATTACHED DEVIATION
TUBE

TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-26	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -8 & -28	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY: COLE	.X ± .1 SURFACES = 125/
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED:	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 11/07/2019	USED ON MODEL
SHEET 37 OF 76	MD-500

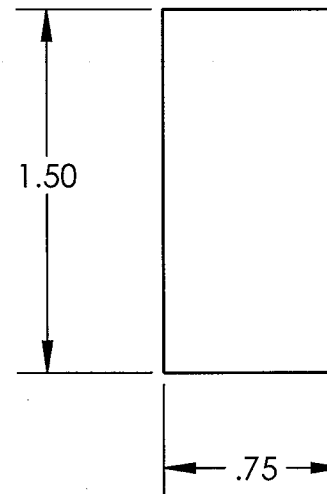
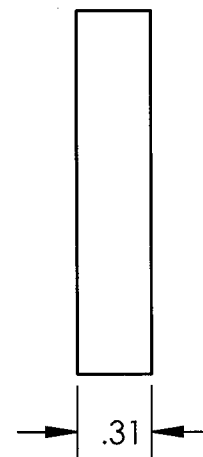
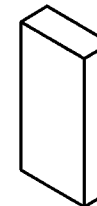
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(-27) SEE ATTACHED DEVIATION
ENGINE ATTACH

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-27	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -28	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSA	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 38 OF 76	

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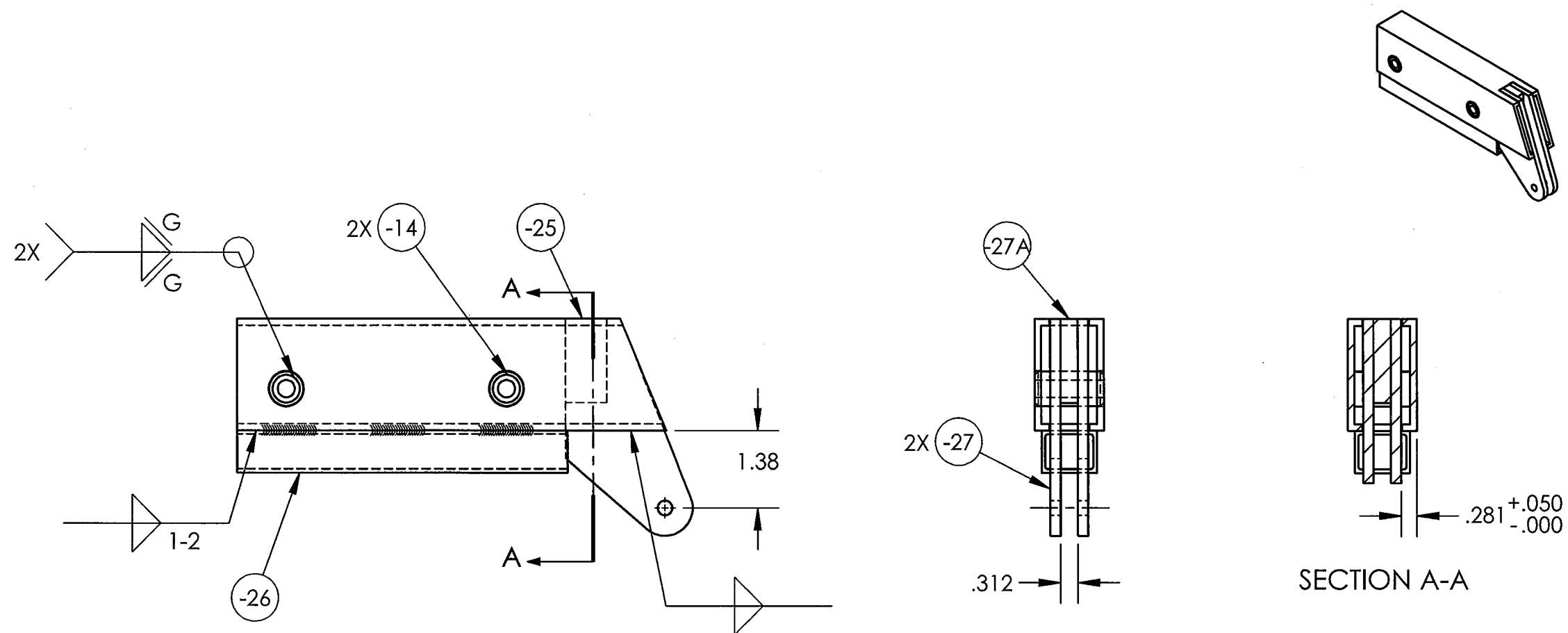
(-27A)

SPACER

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-27A	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -28	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:1	DATE 11/07/2019
SHEET 39 OF 76	

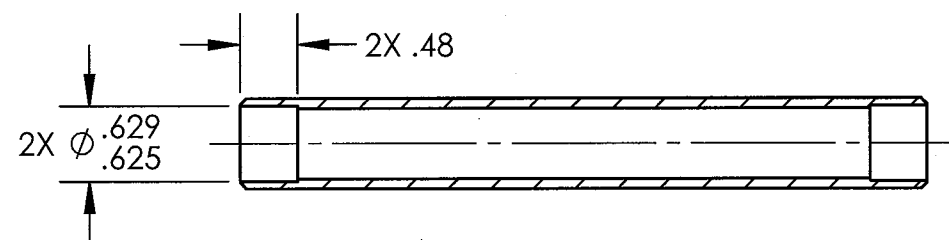
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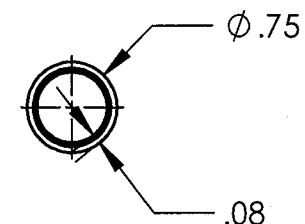
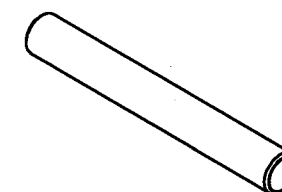
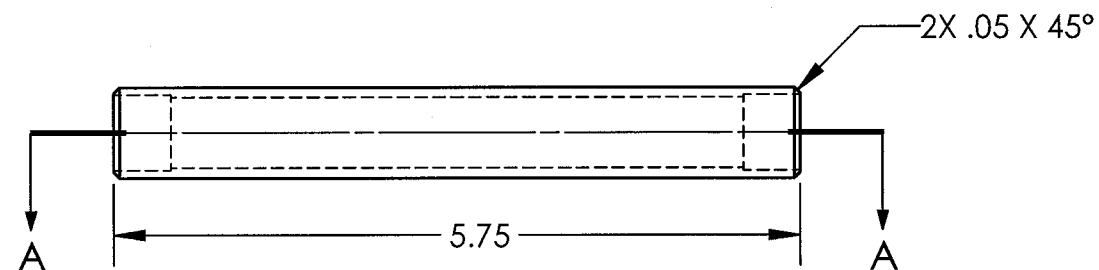
(-28) **SEE ATTACHED DEVIATION**
ENGINE ADAPTER ASSEMBLY

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-28	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:3	DATE 11/07/2019
SHEET 40 OF 76	

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SECTION A-A



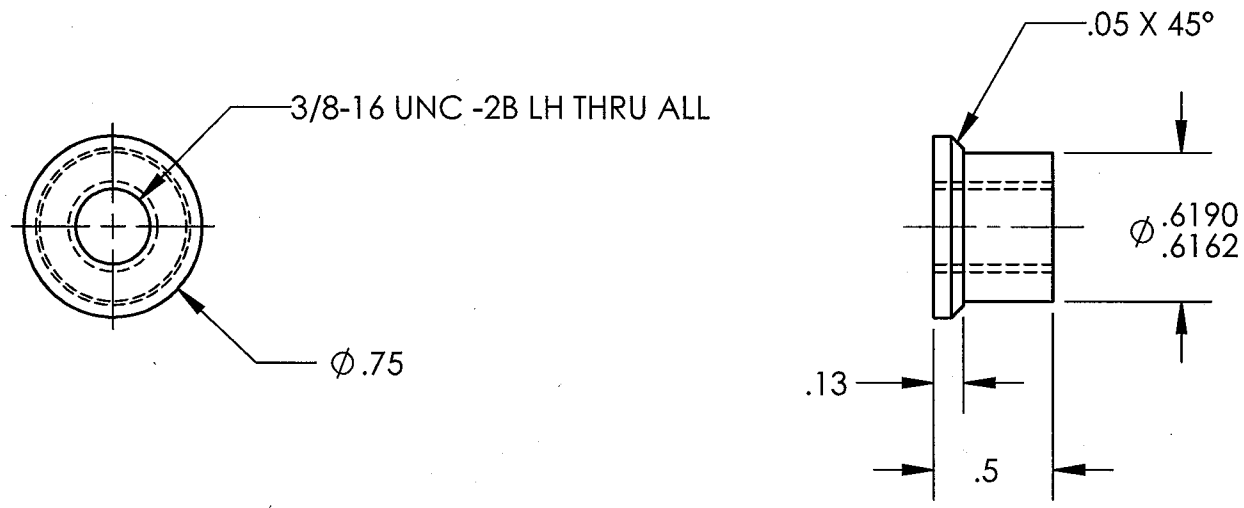
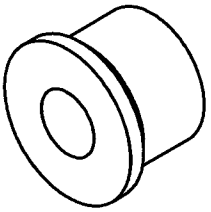
(-29)

TUBE

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-29	REV L
MAT'L CDS HEAT TREAT FINISH SEE -43 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	MD-500
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: [Signature]	
SCALE 1:2	DATE 11/07/2019 SHEET 41 OF 76

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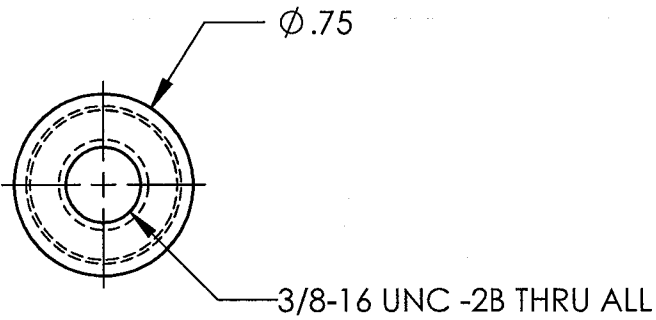
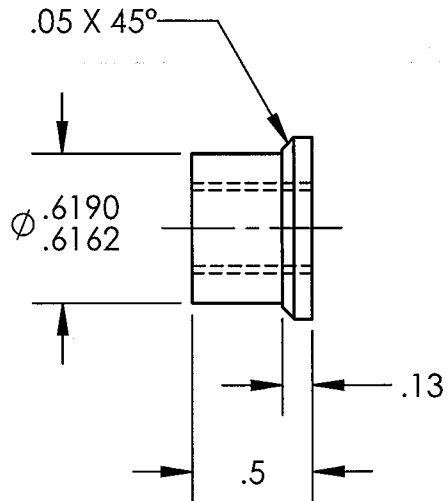
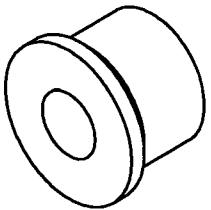
(-31)

SEE ATTACHED DEVIATION

LH THREADED BUSHING

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-31	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -43 & -51	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 42 OF 76

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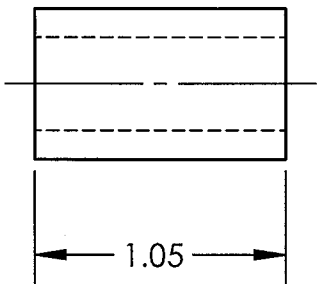
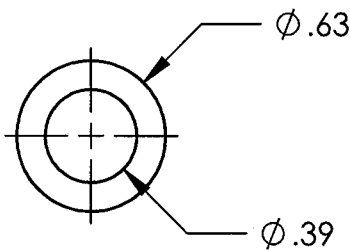
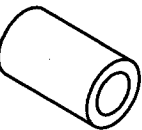


(-33) SEE ATTACHED DEVIATION

THREADED BUSHING

TITLE MD-500 ENGINE LIFT			
DWG NO. RBT18625-33			REV L
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH SEE -43 & -51		.XX ± .01 ANGLES ± .5°	
SPEC		.X ± .1 SURFACES = 125/	
DRAWN BY:	COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	LINDSAY	USED ON MODEL	
APPROVED:		MD-500	
SCALE	1:1	DATE	11/07/2019
		SHEET 43 OF 76	

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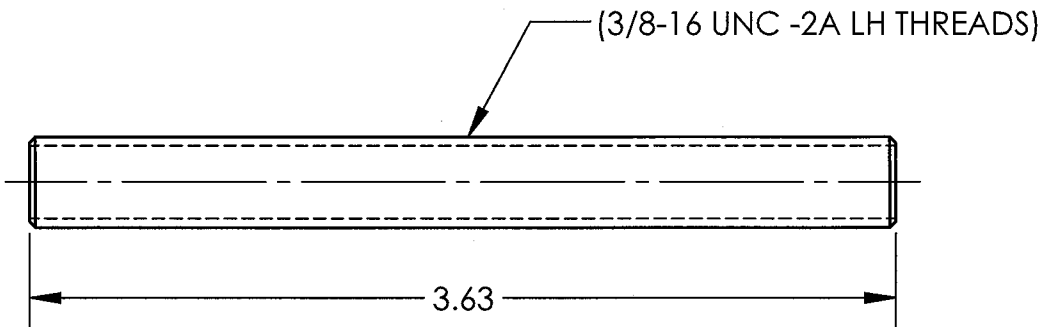
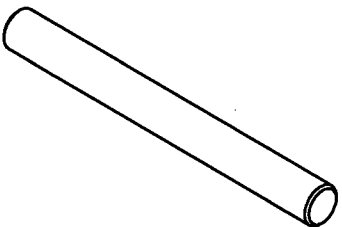
(-35)

SEE ATTACHED DEVIATION

EYE

TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-35	REV L
MAT'L CDS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -43 & -51	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm .5°
	.X \pm .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 44 OF 76	

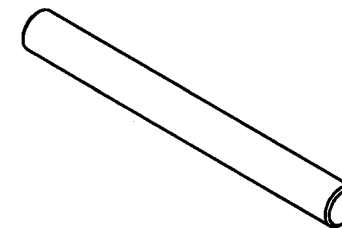
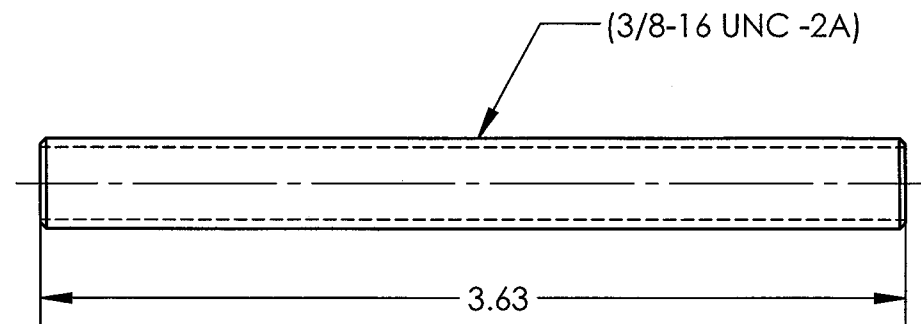
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(-37) **SEE ATTACHED DEVIATION**
LH THREADED STUD

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-37	REV L
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -43	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 45 OF 76	

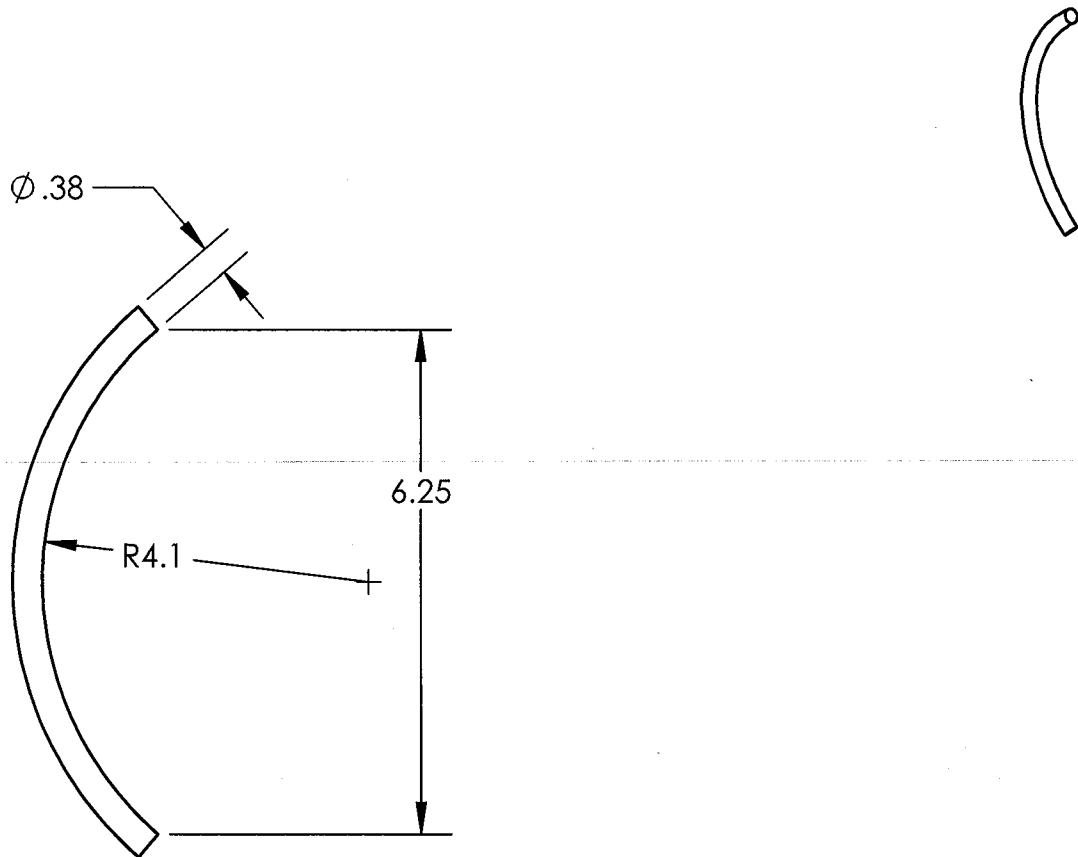
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(-39) SEE ATTACHED DEVIATION
THREADED STUD

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-39	REV L
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -43	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 46 OF 76

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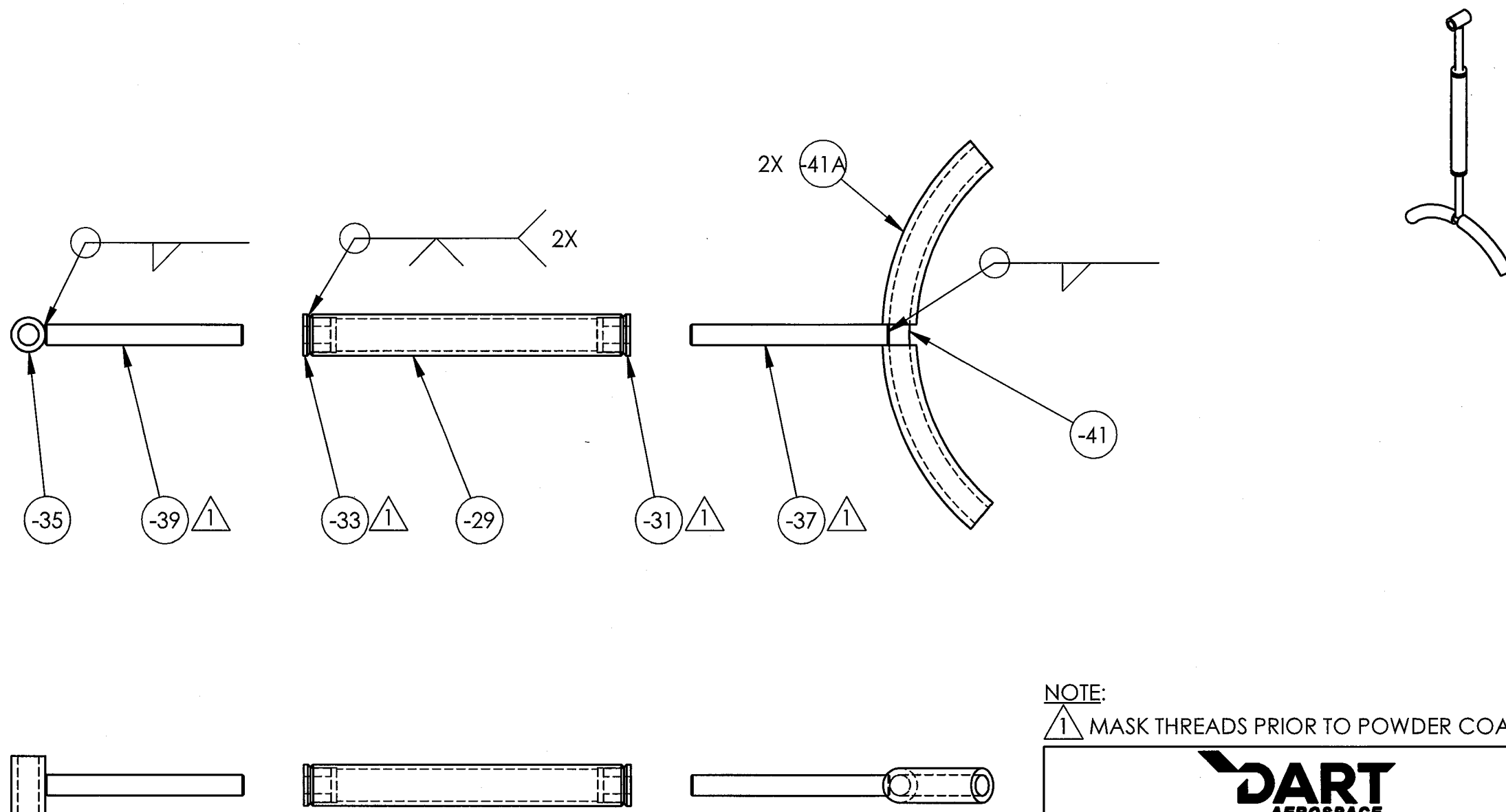
(-41)

ARCH

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-41	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -43 OR -51	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019
SHEET 47 OF 76	

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NOTE:

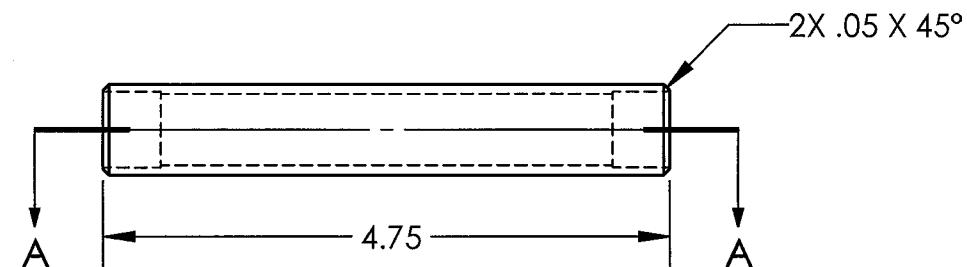
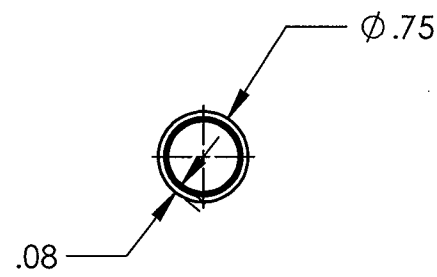
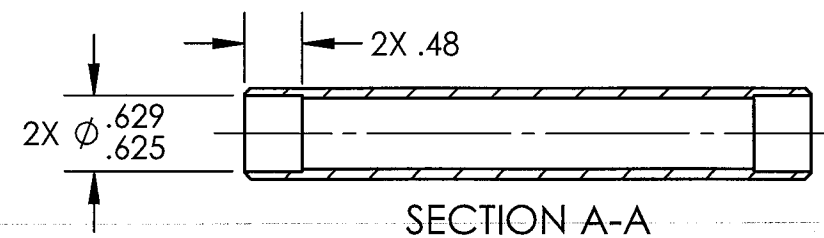
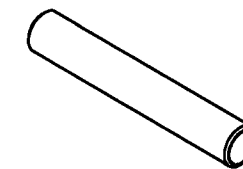
1 MASK THREADS PRIOR TO POWDER COATING.

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-43	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	MD-500
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED:	
SCALE 1:3	DATE 11/07/2019
SHEET 48 OF 76	

-43 SEE ATTACHED DEVIATION

LARGE TURNBUCKLE ASSEMBLY

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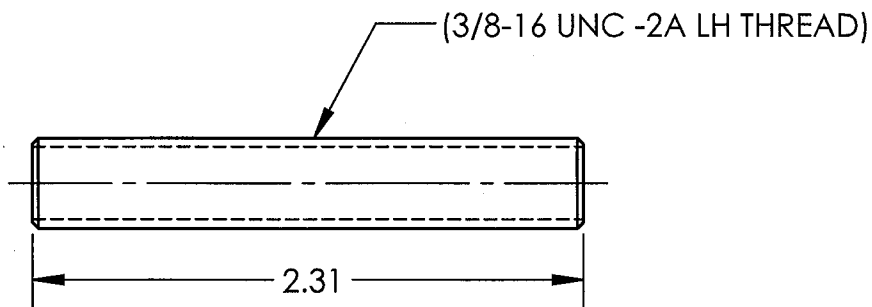
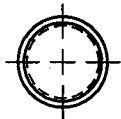
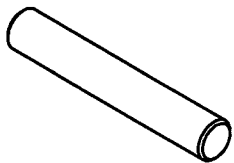
(-45)

TUBE

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-45	REV L
MAT'L CDS HEAT TREAT FINISH SEE -51 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm .5° .X \pm .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 49 OF 76	

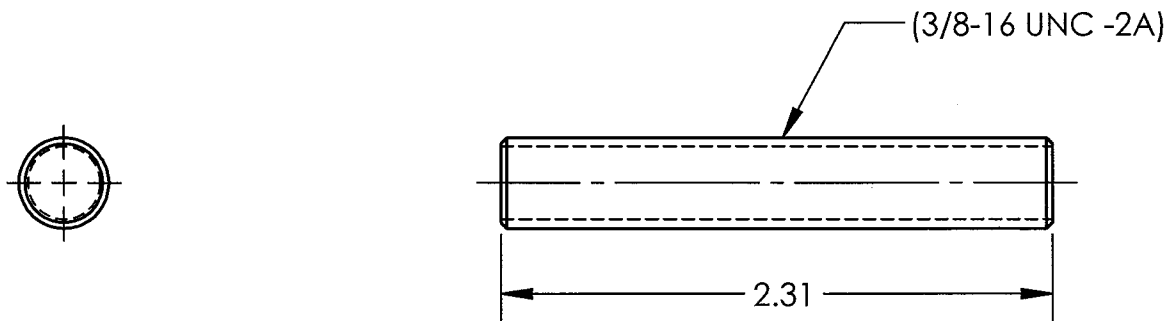
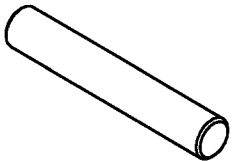
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(-47) **SEE ATTACHED DEVIATION**
LH THREADED STUD

TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-47	REV L
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -51	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ±.5°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 50 OF 76	

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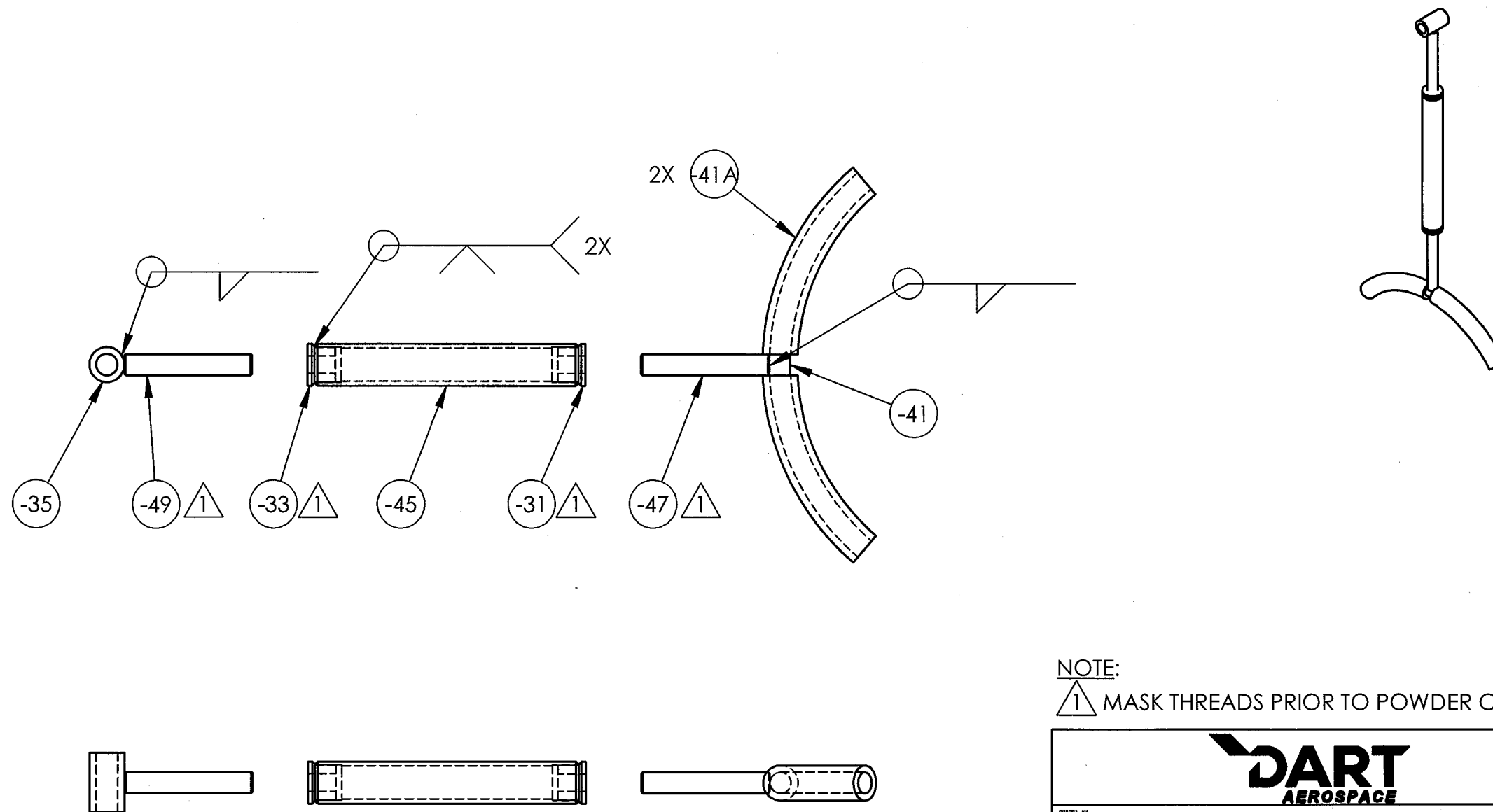
-49

SEE ATTACHED DEVIATION

THREADED STUD

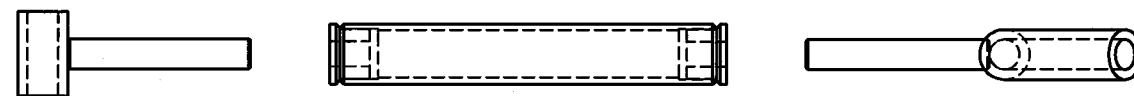
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-49	REV L
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -51	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: [Signature]	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 51 OF 76	

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NOTE:

1 MASK THREADS PRIOR TO POWDER COATING.



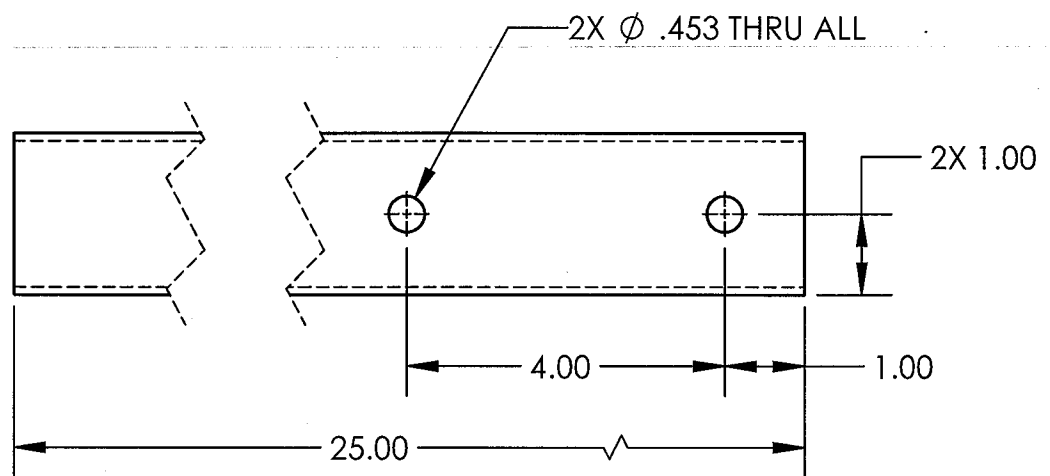
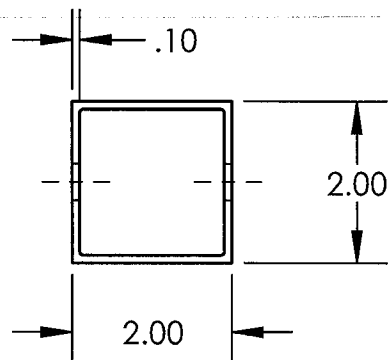
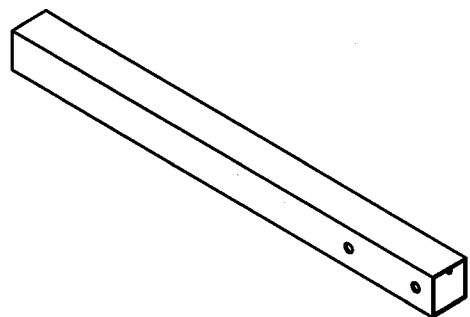
-51

SEE ATTACHED DEVIATION

SMALL TURNBUCKLE ASSEMBLY

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-51	REV L
MAT'L HEAT TREAT FINISH POWDER COAT BLACK SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:3	DATE 11/07/2019 SHEET 52 OF 76

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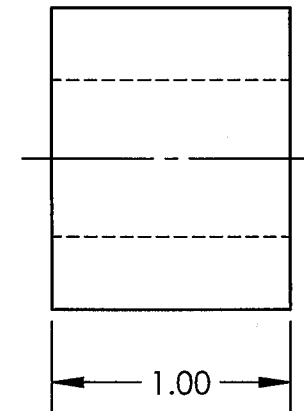
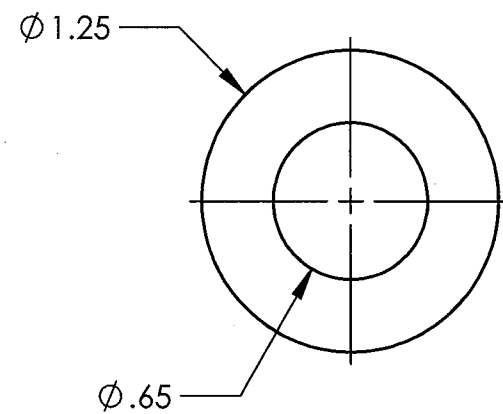
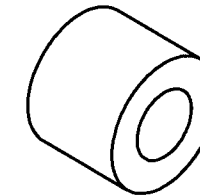
(-53)

SEE ATTACHED DEVIATION

UPRIGHT

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-53	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -54	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:3	DATE 11/07/2019
SHEET 53 OF 76	

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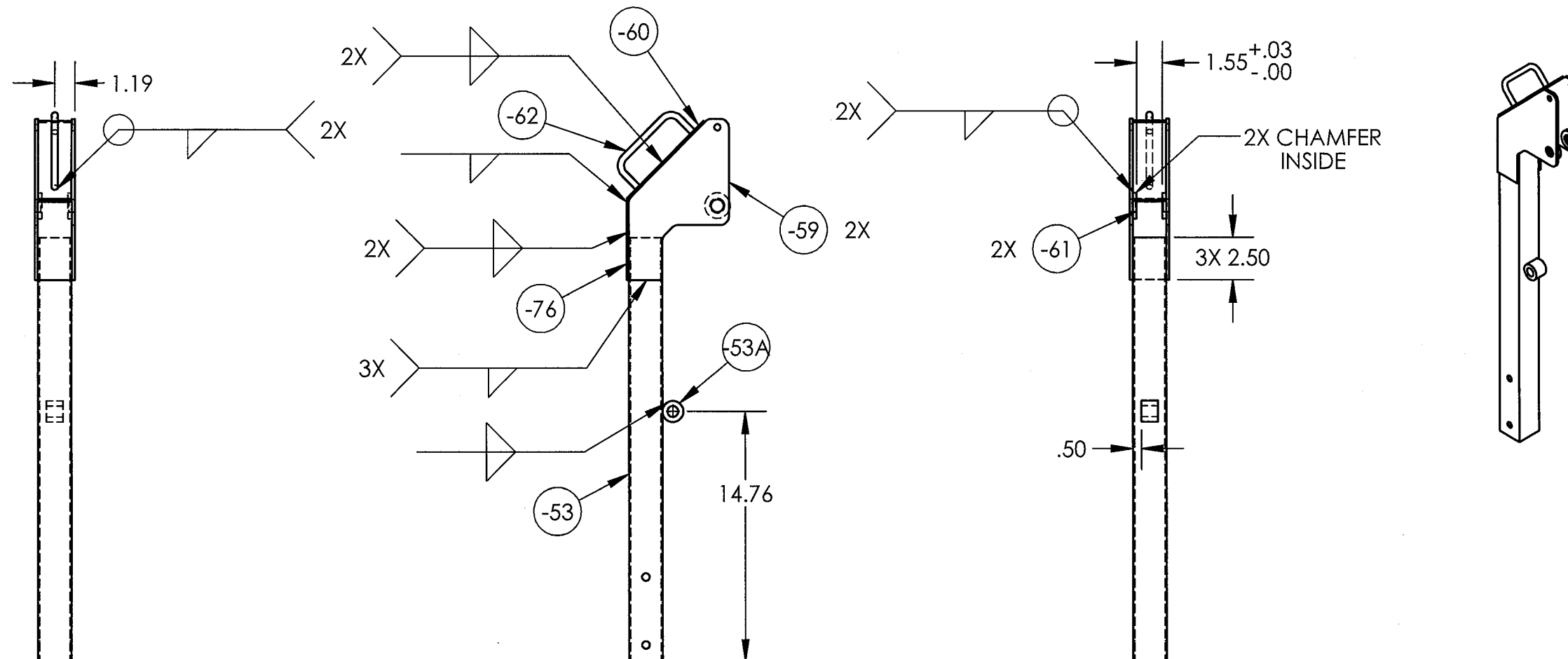
-53A

SEE ATTACHED DEVIATION

STORAGE RING

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-53A	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -54	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 54 OF 76

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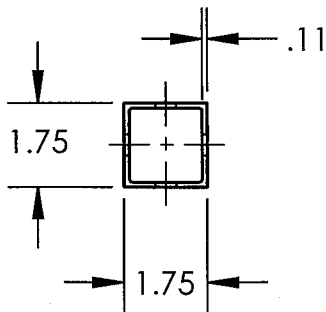
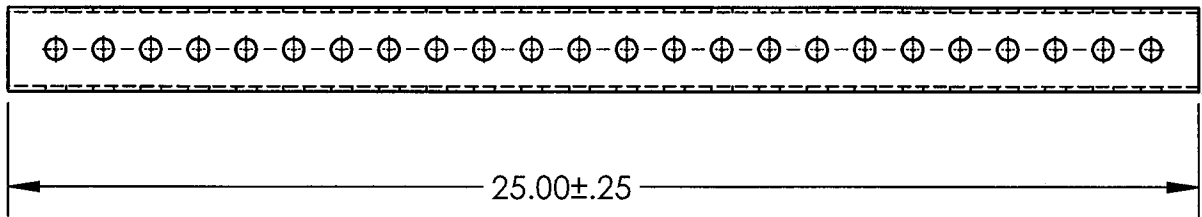
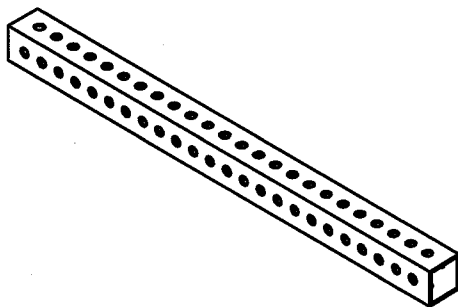
SEE ATTACHED DEVIATION

(-54)

UPRIGHT ASSEMBLY

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-54	REV L
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT BLACK	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSA	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:10	USED ON MODEL
DATE 11/07/2019	MD-500
	SHEET 55 OF 76

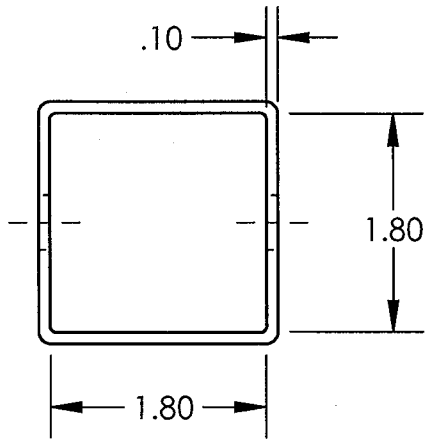
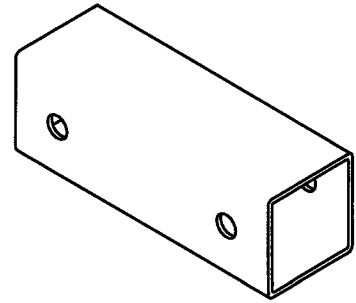
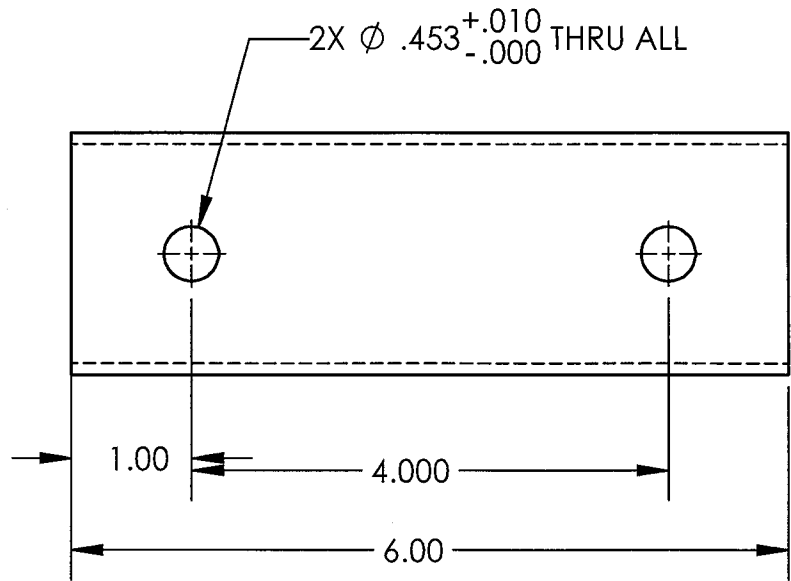
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(-55) SEE ATTACHED DEVIATION
MAST

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-55	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:5	DATE 11/07/2019 SHEET 56 OF 76

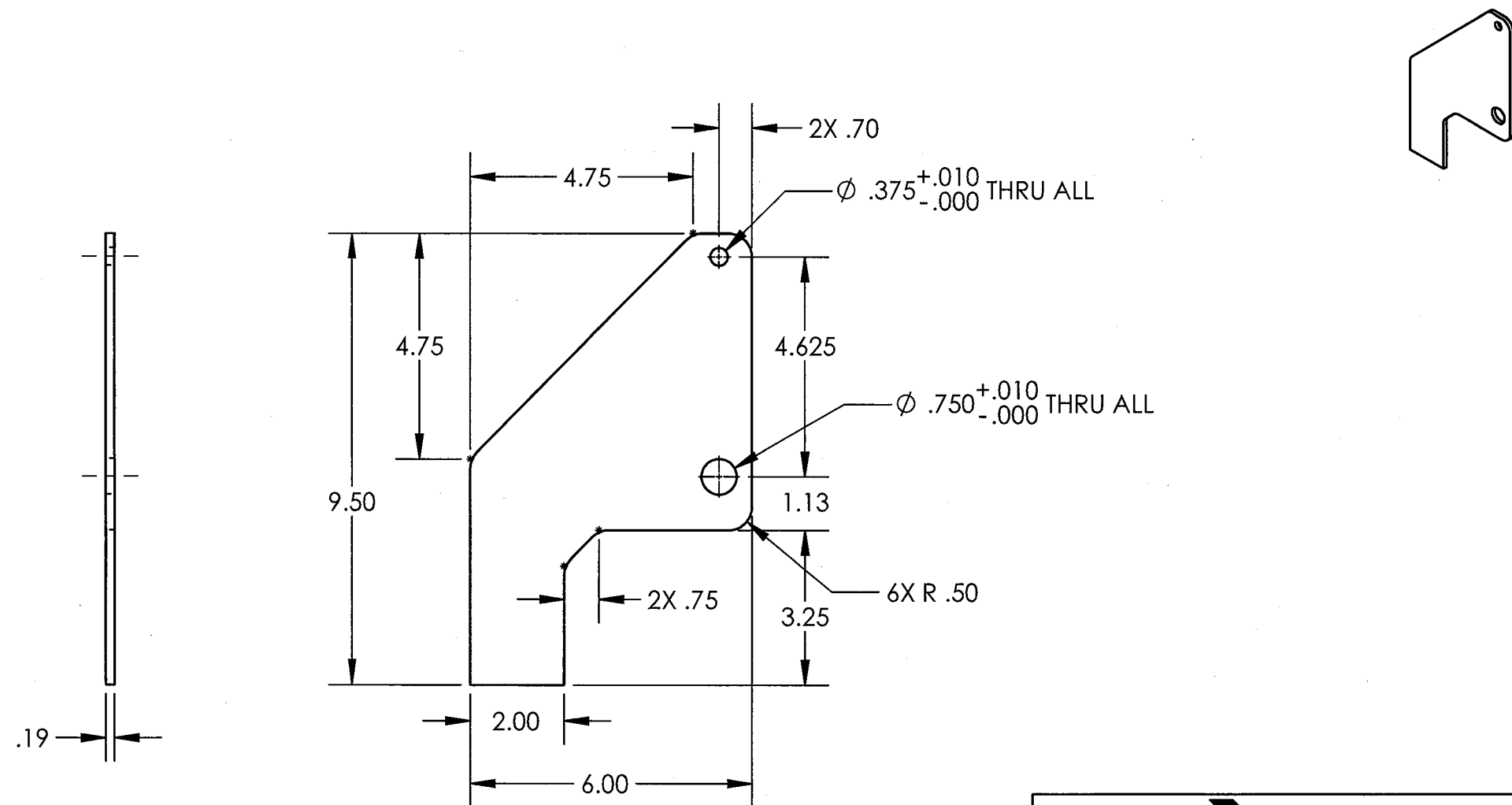
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(-57) SEE ATTACHED DEVIATION
SOCKET

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-57	REV L
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -66	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 57 OF 76	

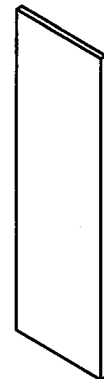
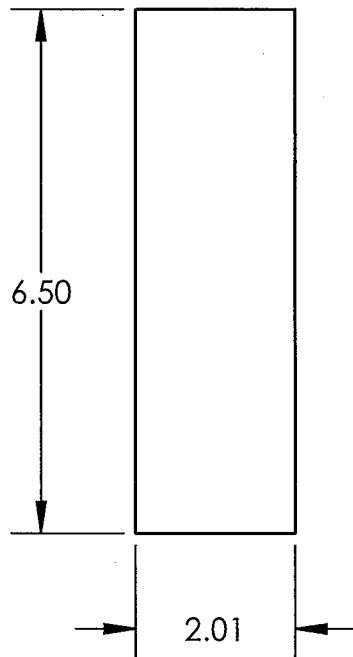
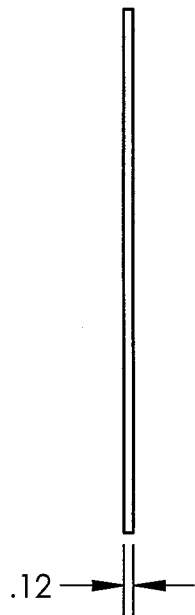
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(-59) **SEE ATTACHED DEVIATION**
PIVOT BRACKET

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-59	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .010 FRACTIONS \pm 1/8
FINISH SEE -54	.XX \pm .03 ANGLES \pm 1°
SPEC	.X \pm .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:4	DATE 11/07/2019 SHEET 58 OF 76

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(-60)

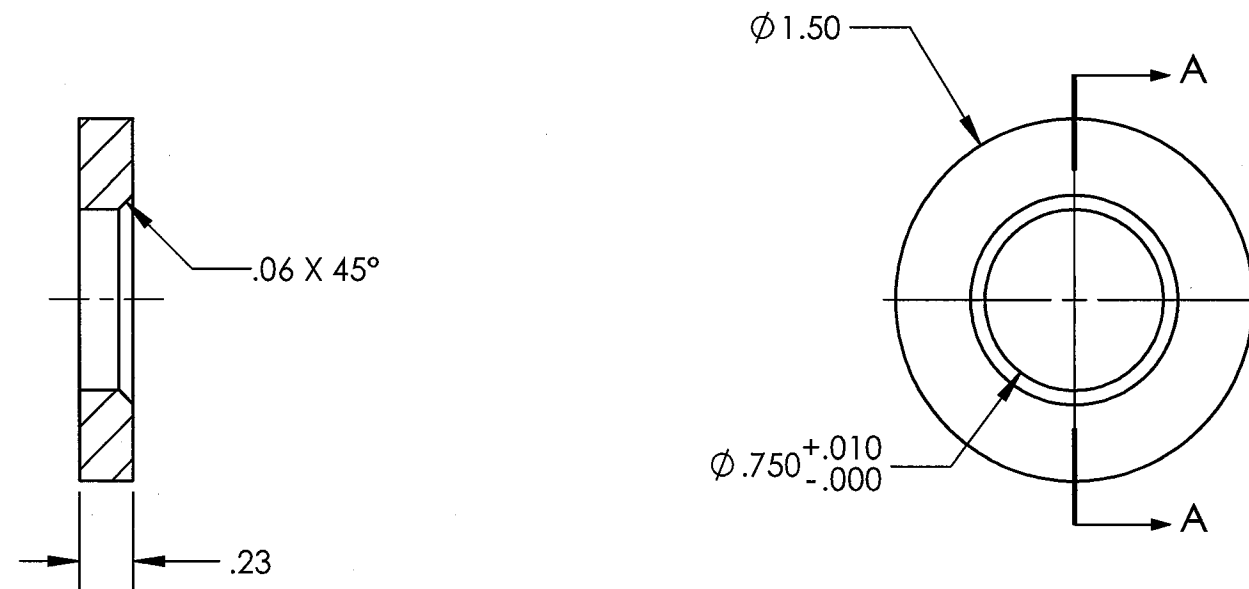
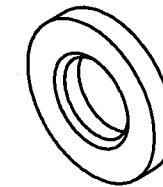
SEE ATTACHED DEVIATION

HANDLE PLATE



TITLE		MD-500 ENGINE LIFT	
DWG NO.		RBT18625-60	
REV		L	
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -54		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE 1:3		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 11/07/2019		USED ON MODEL	
SHEET 59 OF 76		MD-500	

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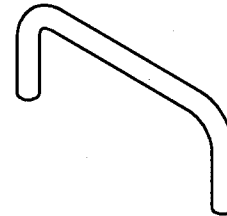
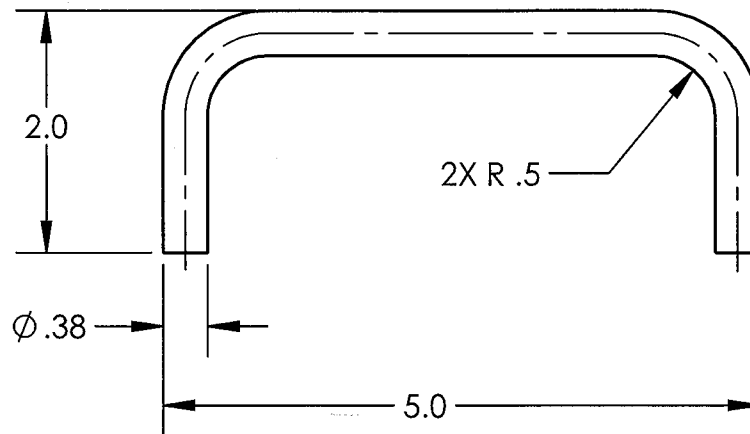
SECTION A-A

(-61) SEE ATTACHED DEVIATION

BUSHING

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-61	REV L
MAT'L DOM HEAT TREAT FINISH SEE -54 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 60 OF 76

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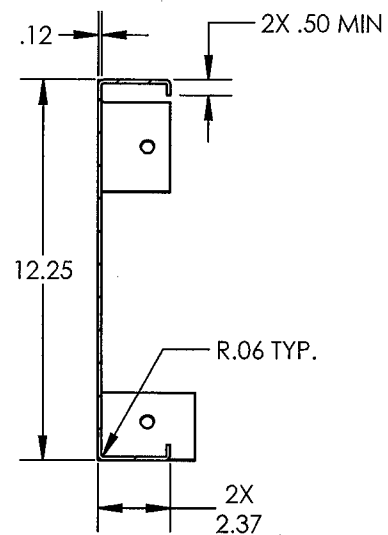
SEE ATTACHED DEVIATION

HANDLE

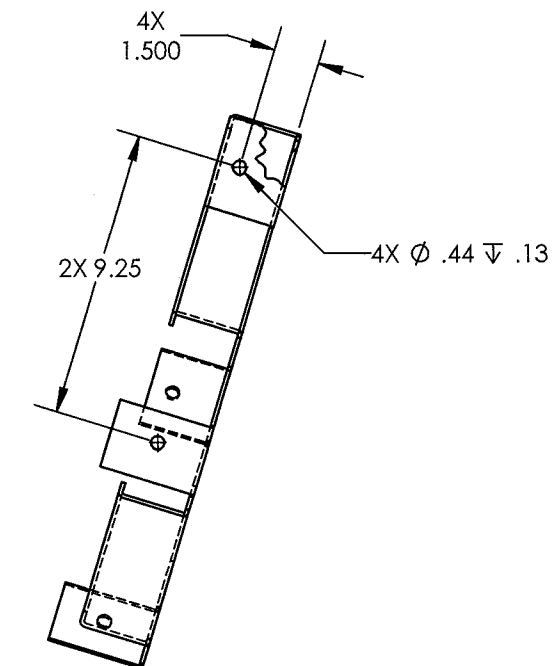
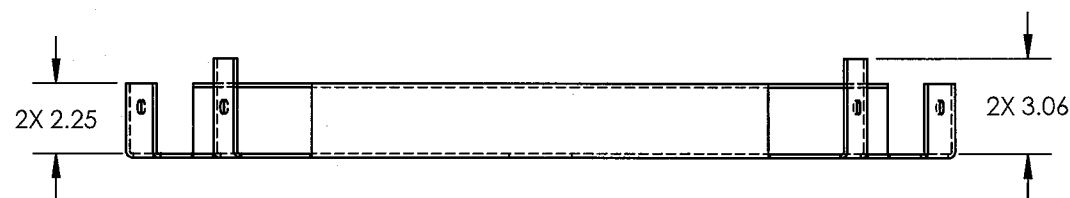
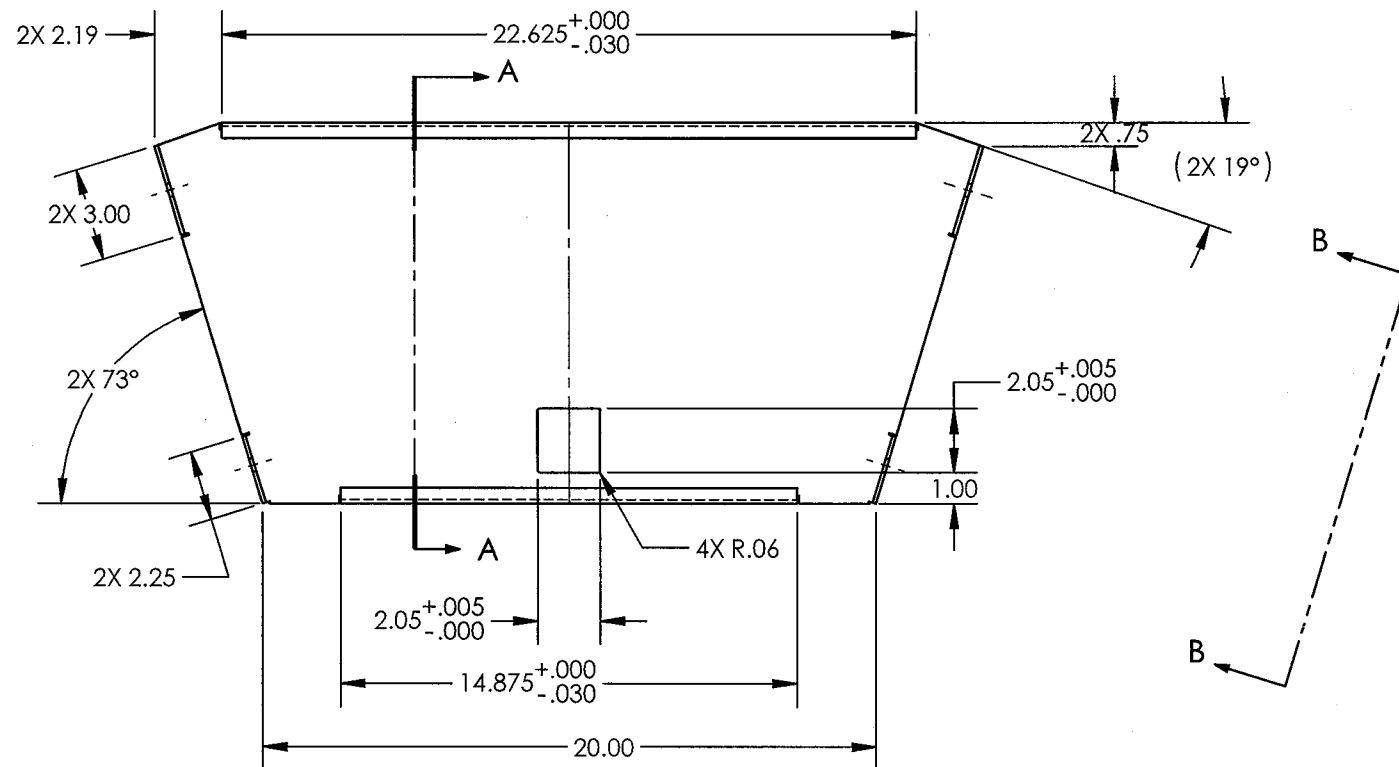


TITLE		MD-500 ENGINE LIFT	
DWG NO.		RBT18625-62	
REV		L	
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -54		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 11/07/2019		USED ON MODEL	
SHEET 61 OF 76		MD-500	

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SECTION A-A



VIEW B-B

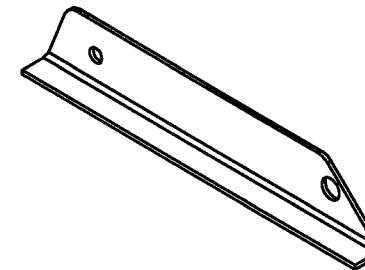
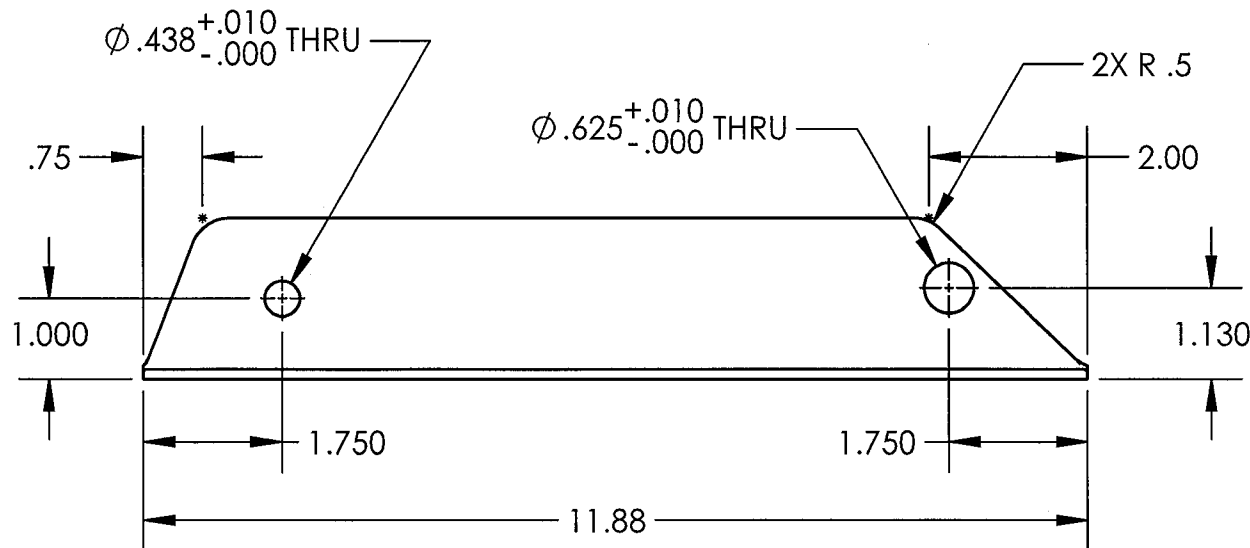
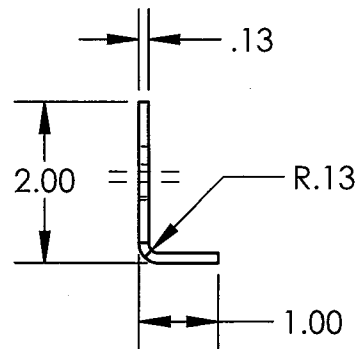
SEE ATTACHED DEVIATION

-63

BASE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-63	REV L
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT FINISH SEE -66	.XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/
SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD-500
APPROVED: [Signature]	
SCALE 1:6	DATE 11/07/2019
SHEET 62 OF 76	

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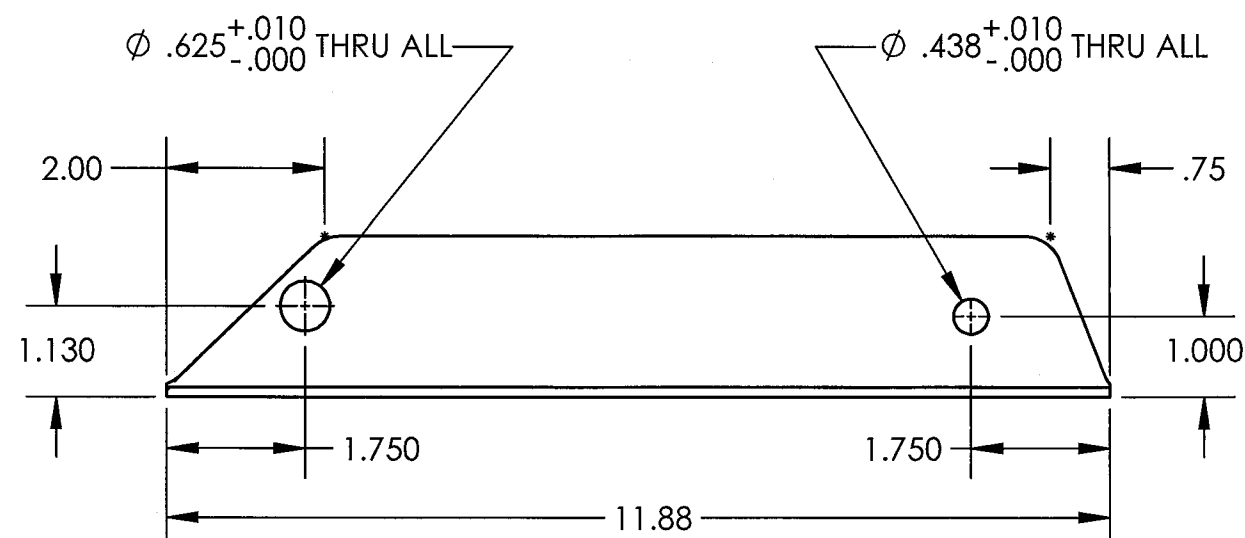
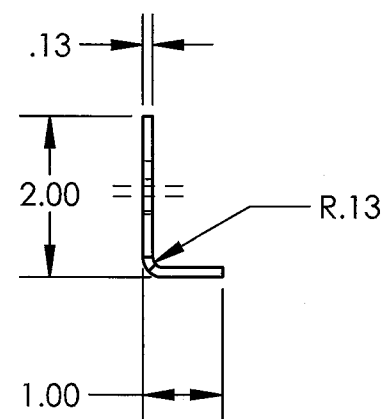
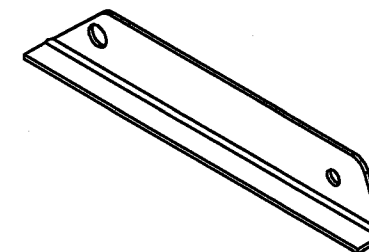


(-65L) SEE ATTACHED DEVIATION

ANGLE BRACKET

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-65L	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -66	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	
SCALE 1:3	DATE 11/07/2019 SHEET 63 OF 76

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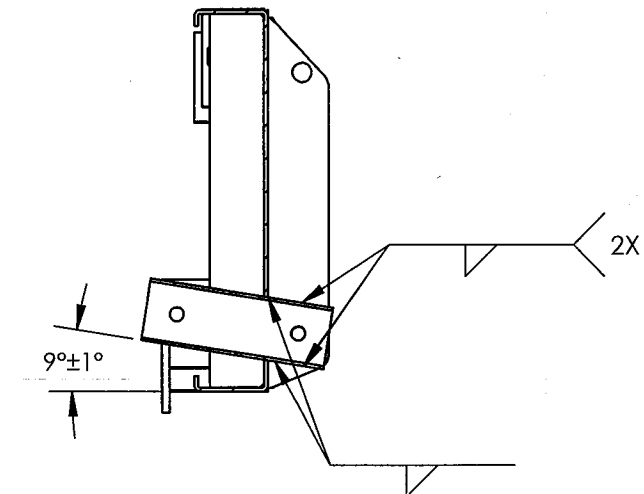
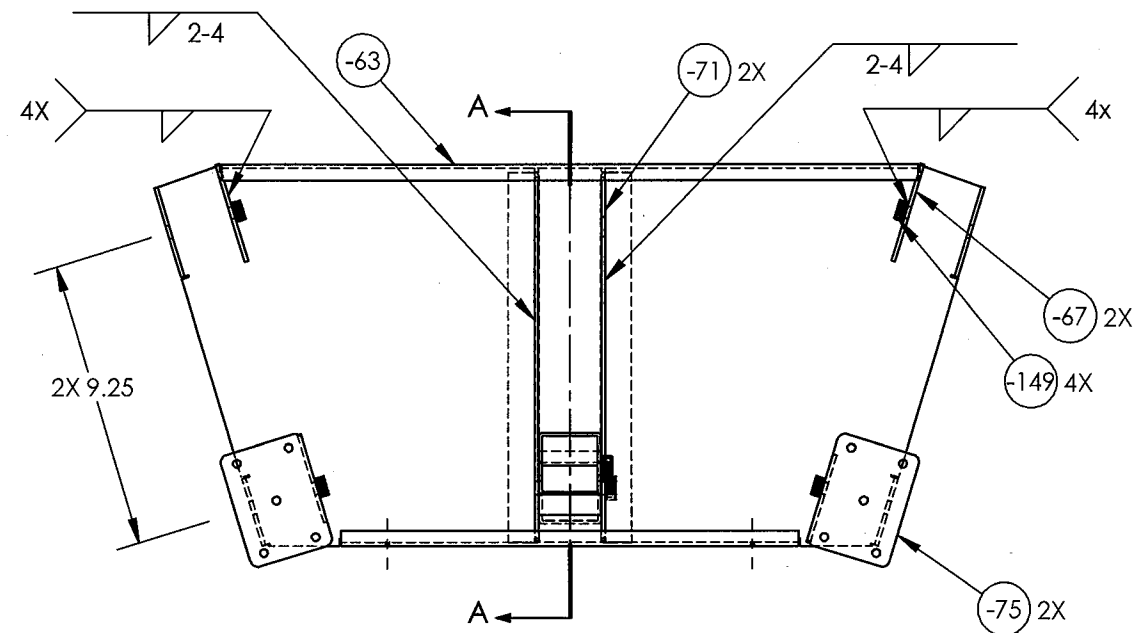
-65R

SEE ATTACHED DEVIATION

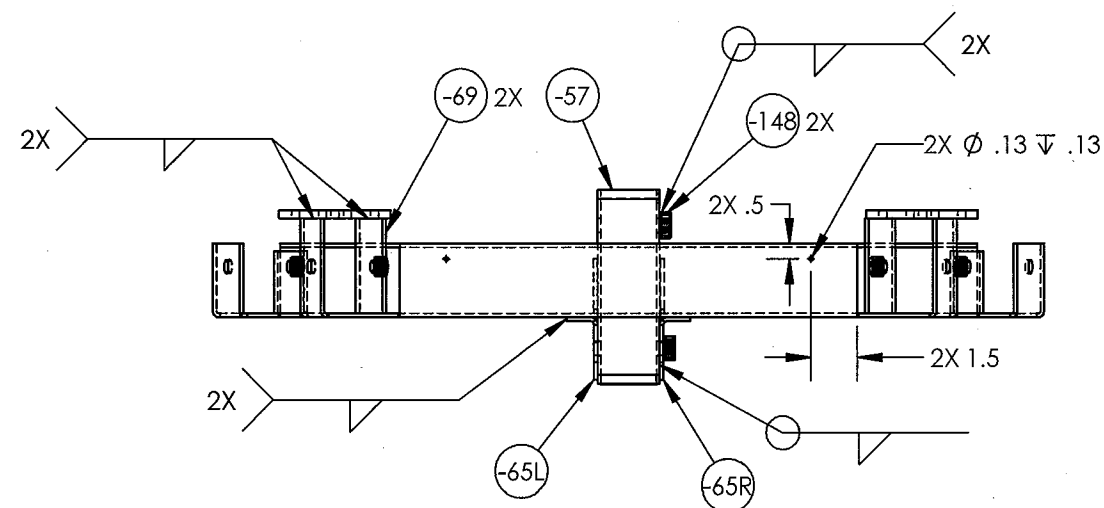
ANGLE BRACKET

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-65R	REV L
MAT'L A361018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .010 FRACTIONS \pm 1/8
FINISH SEE -66	.XX \pm .03 ANGLES \pm 1°
SPEC	.X \pm .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:3	DATE 11/07/2019 SHEET 64 OF 76

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SECTION A-A



SEE ATTACHED DEVIATION

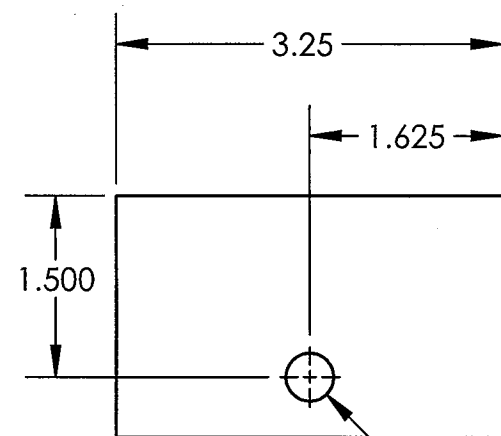
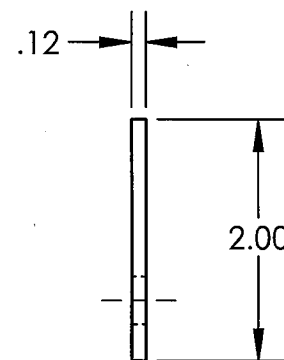
-66

BASE PLATE ASSEMBLY

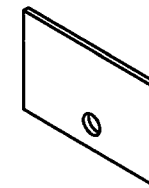
NOTE:
USE WELD FIXTURE RBT18625-66 TO POSITION FOR WELDING.

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-66	REV L
MATERIAL HEAT TREAT FINISH POWDER COAT BLACK SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE	USED ON MODEL MD-500
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: [Signature]	
SCALE 1:6	DATE 11/07/2019
SHEET 65 OF 76	

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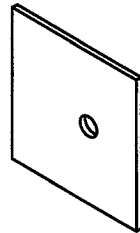
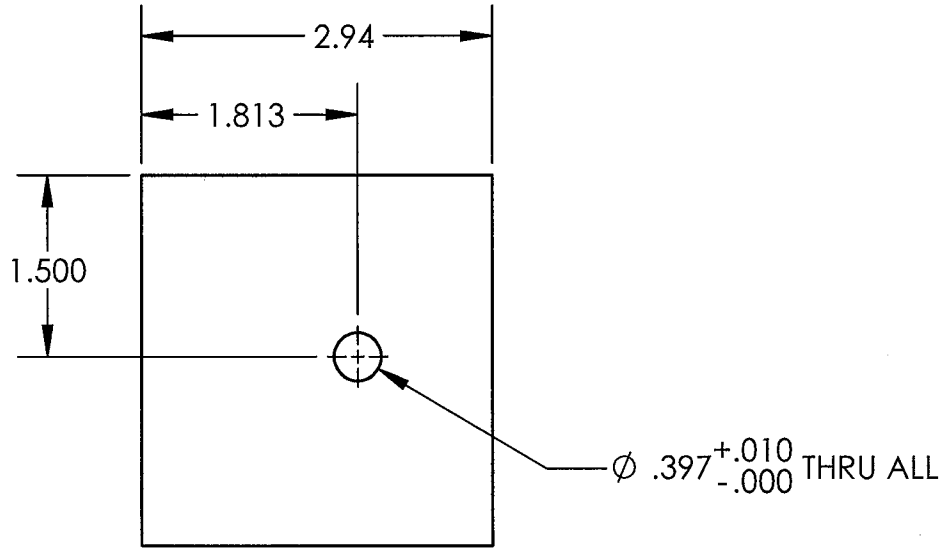
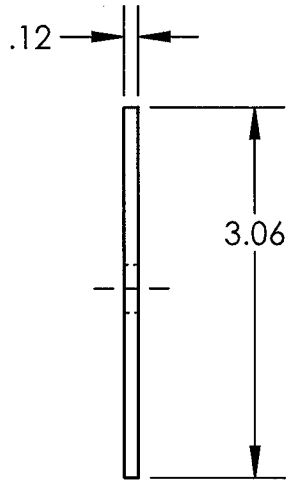
-67

SEE ATTACHED DEVIATION

FORWARD TAB

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-67	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -66	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
	.X \pm .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 11/07/2019	MD-500
SHEET 66 OF 76	

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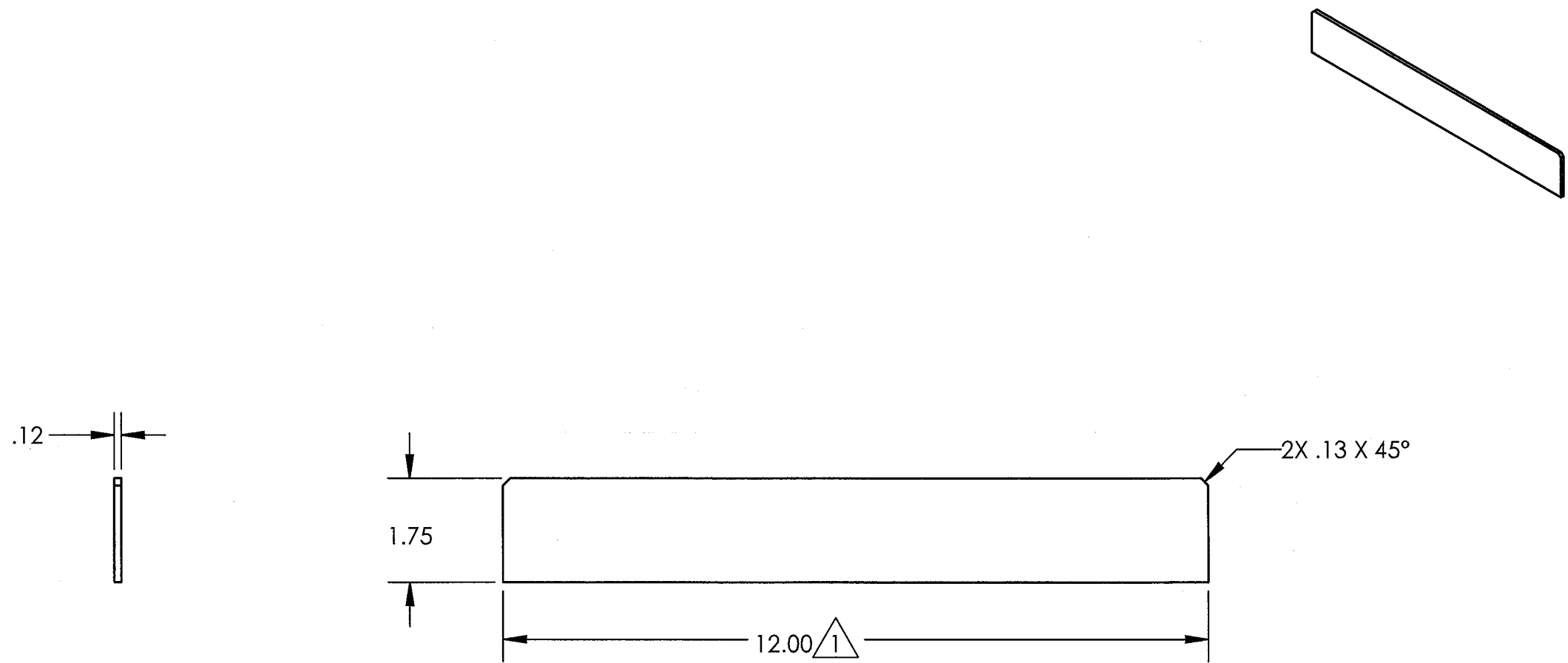
(-69)

AFT TAB

SEE ATTACHED DEVIATION

TITLE MD-500 ENGINE LIFT			
DWG NO. RBT18625-69			REV L
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -66		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 11/07/2019		USED ON MODEL	
SHEET 67 OF 76		MD-500	

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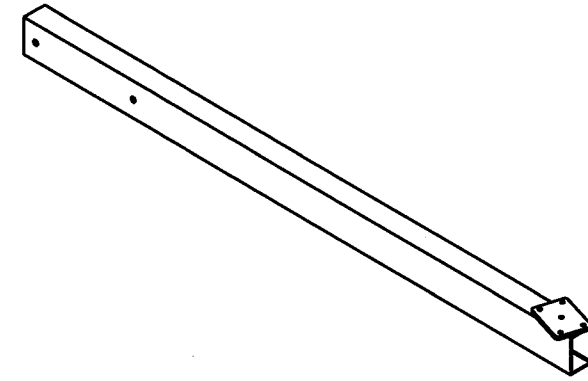
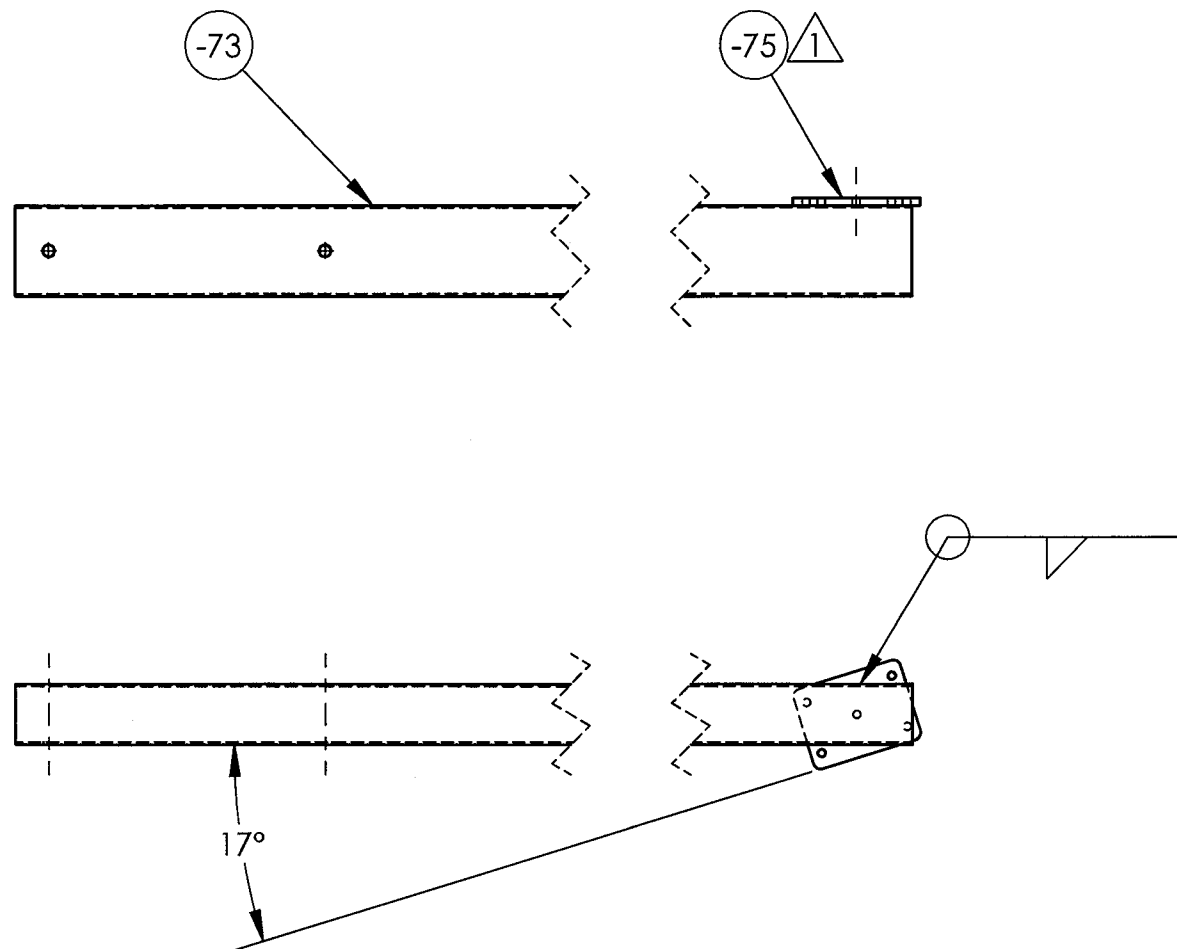


NOTE:
1 GRIND TO FIT INSIDE -66 BASE.

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-71	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -66	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:3	DATE 11/07/2019 SHEET 68 OF 76

(-71) SEE ATTACHED DEVIATION
STIFFENER

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NOTE:

1 ALIGN HOLE IN PLATE WITH HOLE IN TUBE.



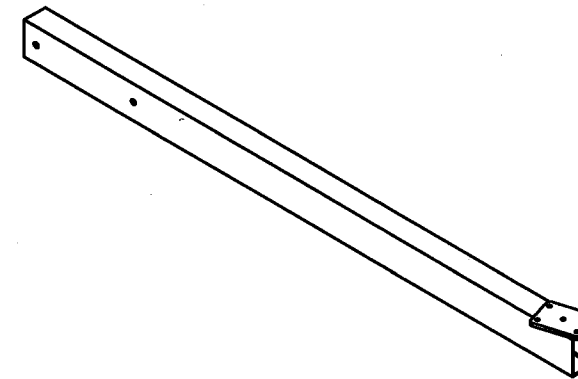
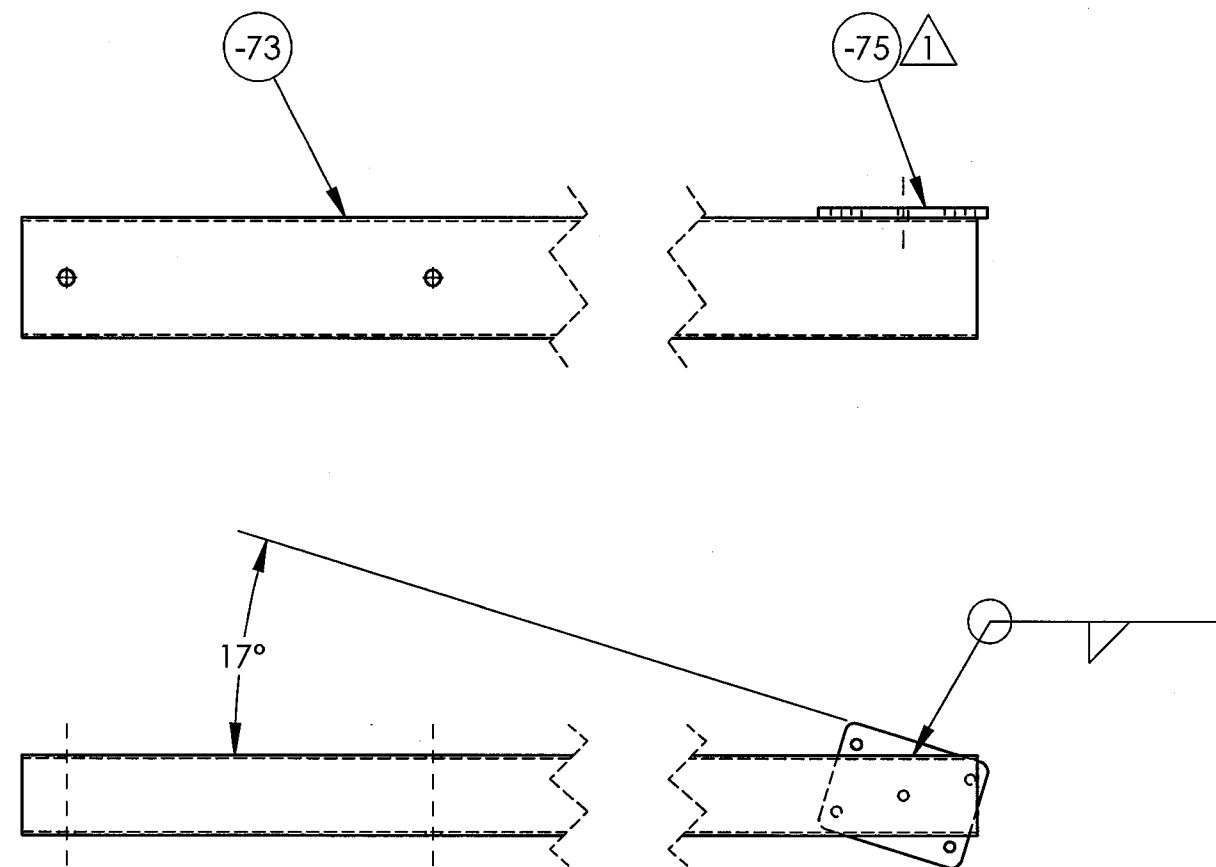
TITLE		MD-500 ENGINE LIFT	
DWG NO.		RBT18625-73L	REV L
MAT'L	UNLESS OTHERWISE SPECIFIED		
HEAT TREAT	DIMENSIONS ARE IN INCHES		
FINISH	POWDER COAT BLACK	.XXX ± .010	FRACTIONS ± 1/8
SPEC		.XX ± .03	ANGLES ± 1°
		.X ± .1	SURFACES = 125✓
DRAWN BY:	COLE	1. BREAK ALL SHARP EDGES	
CHECKED:	DUERFELDT	.015 x 45° OR .015R	
OPPS APPR:	ANDERSON	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	LINDSAY	AFTER PLATING	
APPROVED:		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
SCALE	1:8	DATE	11/07/2019
			SHEET 69 OF 76

-73L

SEE ATTACHED DEVIATION

LEFT LEG WELDMENT

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NOTE:

1 ALIGN HOLE IN PLATE WITH HOLE IN TUBE.

DART
AEROSPACE

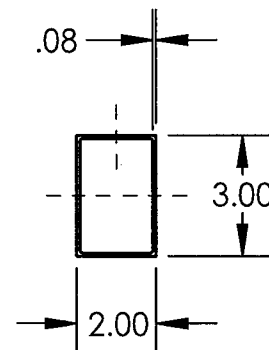
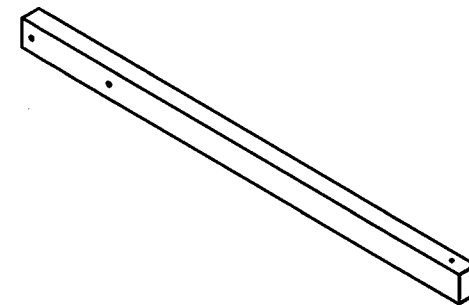
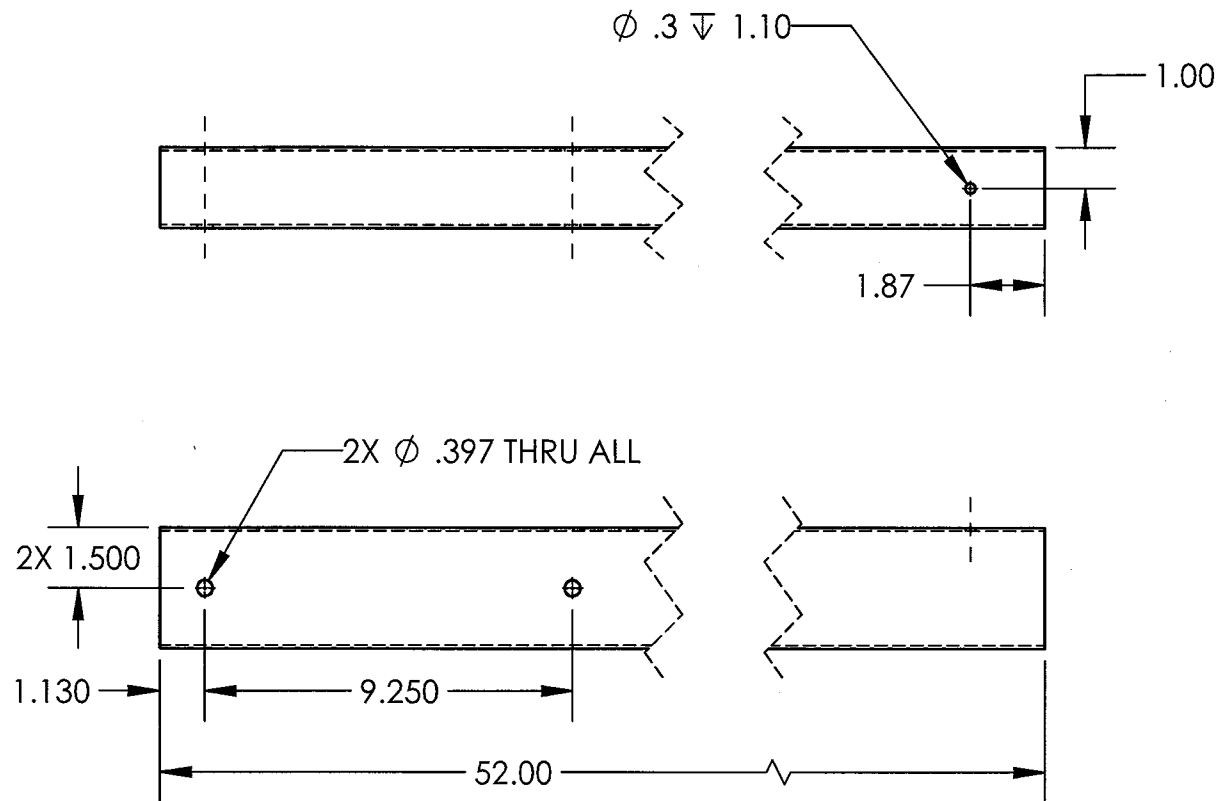
TITLE		MD-500 ENGINE LIFT	
DWG NO.		RBT18625-73R	REV L
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE 1:6		3. INTERPRET DIM AND TOL PER	
DATE 11/07/2019		ASME Y14.5M-2009	
SHEET 70 OF 76		USED ON MODEL	
		MD-500	

-73R

SEE ATTACHED DEVIATION

RIGHT LEG WELDMENT

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(-73)

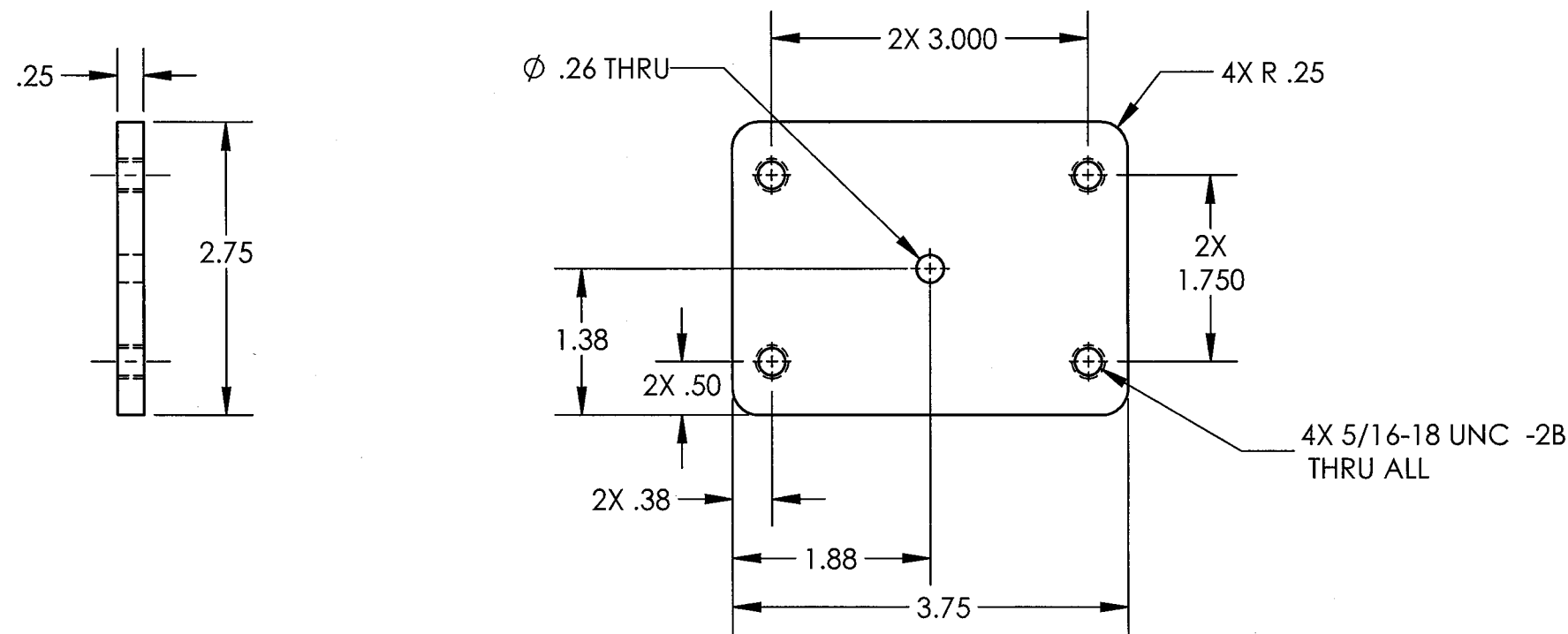
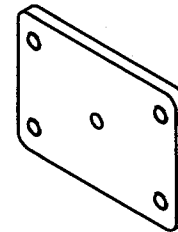
LEG

SEE ATTACHED DEVIATION



TITLE			MD-500 ENGINE LIFT		
DWG NO.			RBT18625-73		
REV			L		
MAT'L			STEEL TUBE		
HEAT TREAT			SEE -73R OR -73L		
SPEC			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
DRAWN BY:			COLE		
CHECKED:			DUERFELDT		
OPPS APPR:			ANDERSON		
QA APPR:			LINDSAY		
APPROVED:			MD-500		
SCALE			1:6		
DATE			11/07/2019		
SHEET			71 OF 76		

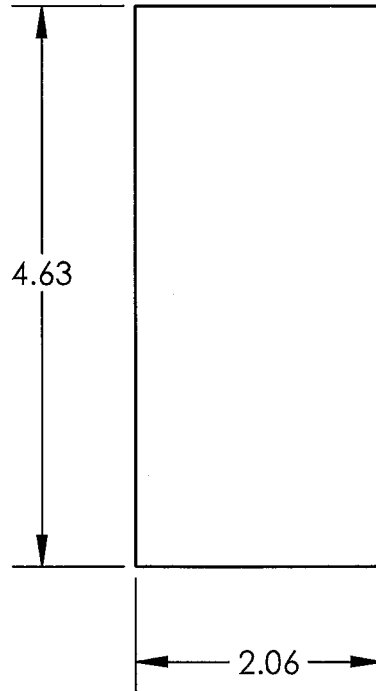
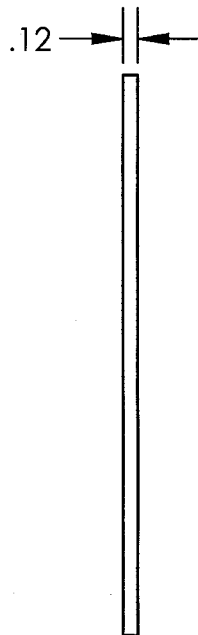
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(-75) SEE ATTACHED DEVIATION
WHEEL PLATE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-75	REV L
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -66, -73R, -73L	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: [Signature]	MD-500
SCALE 1:2	DATE 11/07/2019
SHEET 72 OF 76	

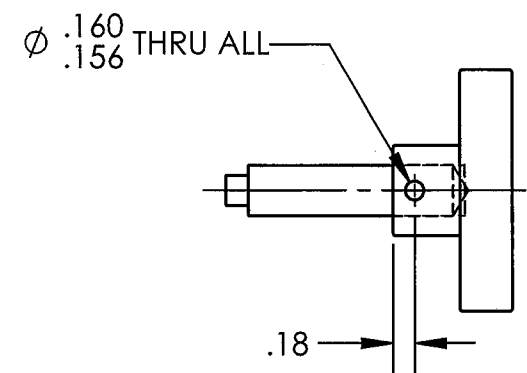
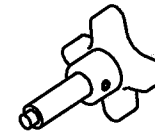
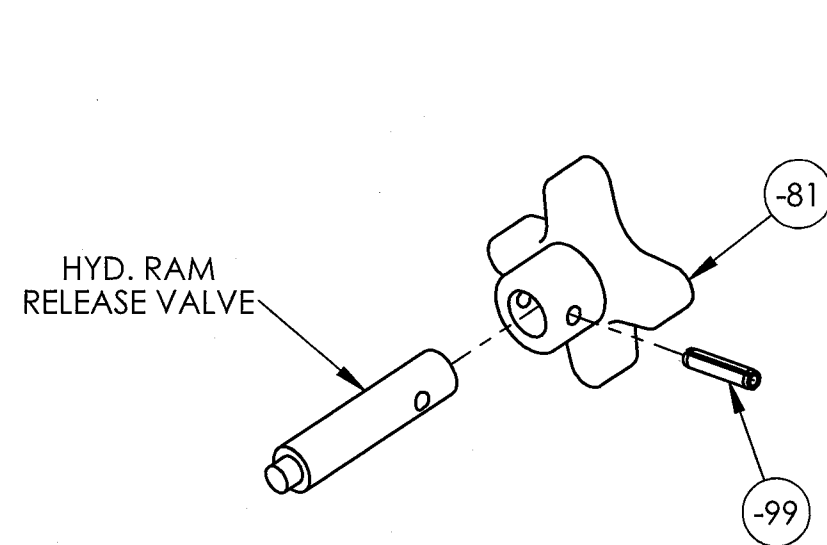
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(-76) **SEE ATTACHED DEVIATION**
BACK PLATE

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-76	REV L
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -54	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:2	DATE 11/07/2019 SHEET 73 OF 76

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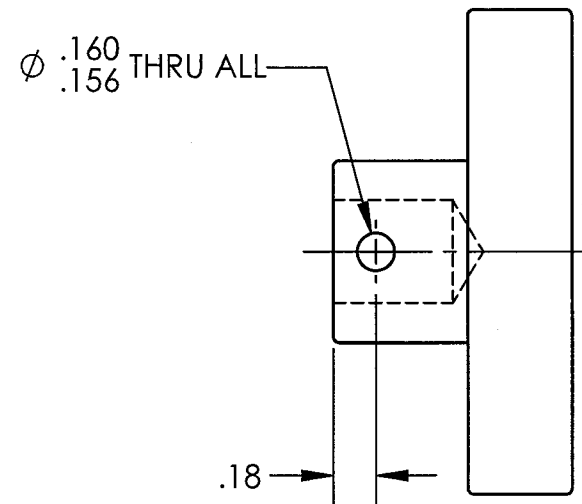
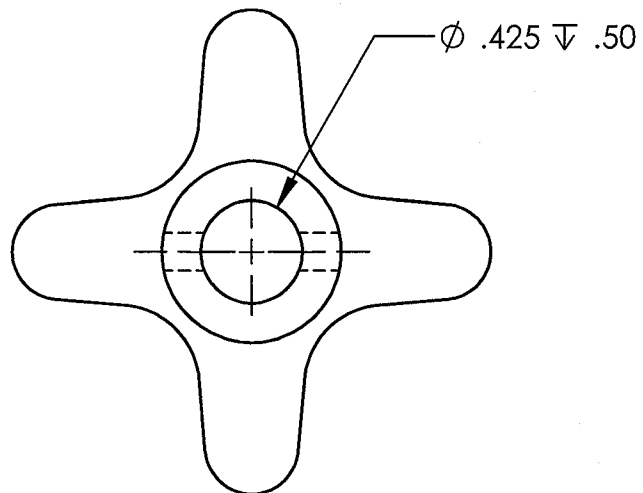
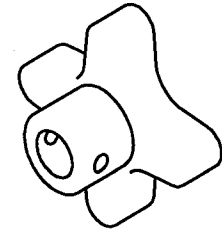
-79

SEE ATTACHED DEVIATION

NOB ASSEMBLY

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-79	REV L
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH	.XX \pm .01 ANGLES \pm .5°
SPEC	.X \pm .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	
SCALE 1:2	DATE 11/07/2019
SHEET 74 OF 76	

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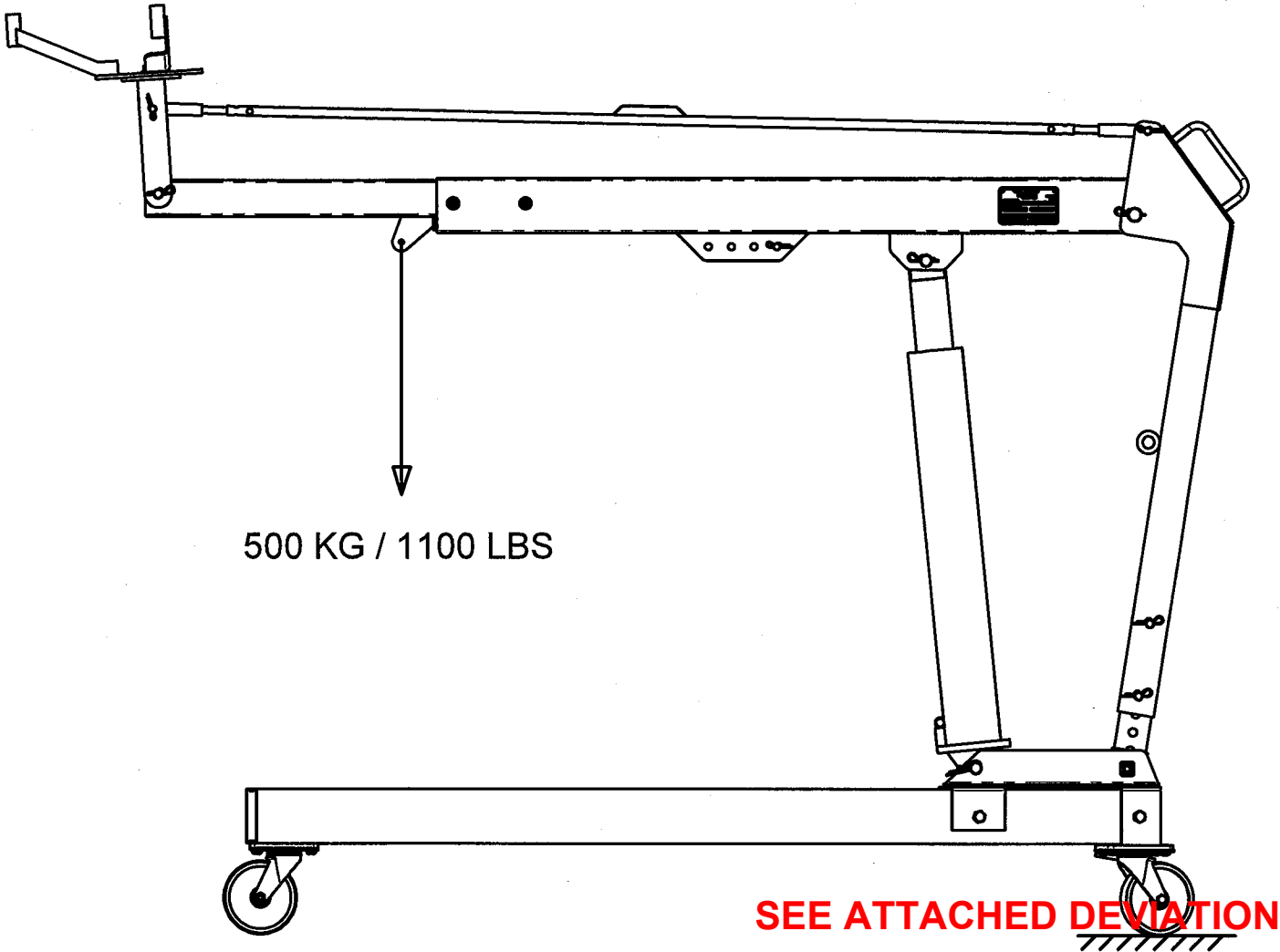
(-81) **SEE ATTACHED DEVIATION**
HAND KNOB

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625-81	REV L
MAT'L IRON	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓
HEAT TREAT	
FINISH BLACK OXIDE	
SPEC	
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED:	MD-500
SCALE 1:1	DATE 11/07/2019 SHEET 75 OF 76

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FIRST ARTICLE LOAD TEST PROCEDURE:

1. AFTER INSPECTION, FIX ENGINE LIFT INTO PLACE BY LOCKING THE REAR CASTER WHEELS. ATTACH AN APPROPRIATE TEST WEIGHT OF 500 KG / 1100 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTIONS, OR DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT ENGINE LIFT, CHECKING FOR CRACKS, DEFLECTIONS, OR DISTORTIONS



INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____

DART AEROSPACE	
TITLE MD-500 ENGINE LIFT	
DWG NO. RBT18625	REV L
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	MD-500
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: [Signature]	
SCALE 1:1	DATE 11/07/2019 SHEET 76 OF 76

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBT18625</u> NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table>				Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																		
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																		
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																		
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval April 12, 2018																	
Description Work Order Deviation		Disposition		Completed By																	
Alternative items for the BOM are listed below: -41A HOSE Ø3/8 ID X 3-5/8 = McMaster Carr 5034K24 -81 HAND KNOB MSC #82397241 = McMaster Carr 6042K39 -146 NO-SKID GASKET SPECIALTIES 1.75 X 7.9 = McMaster Carr 6970T13		- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.		Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment <input type="checkbox"/> Design <input checked="" type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input checked="" type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/>	No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Misabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/>																
OTHER : _____																					